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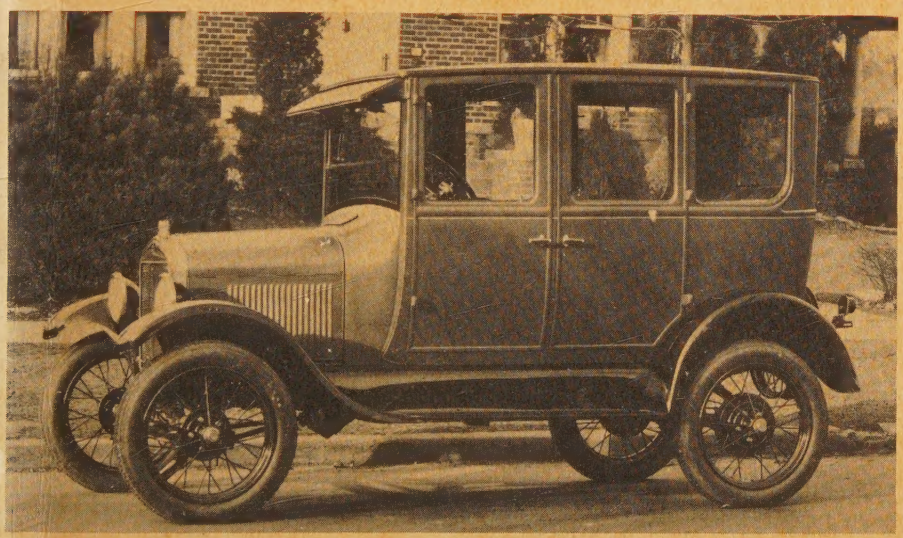
HANDBOOK
OF REPAIR & MAINTENANCE

MODELS T and A

ALSO FORDSON FARM TRACTOR



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AUTOMOTIVE ENTHUSIASTS AND HISTORIANS

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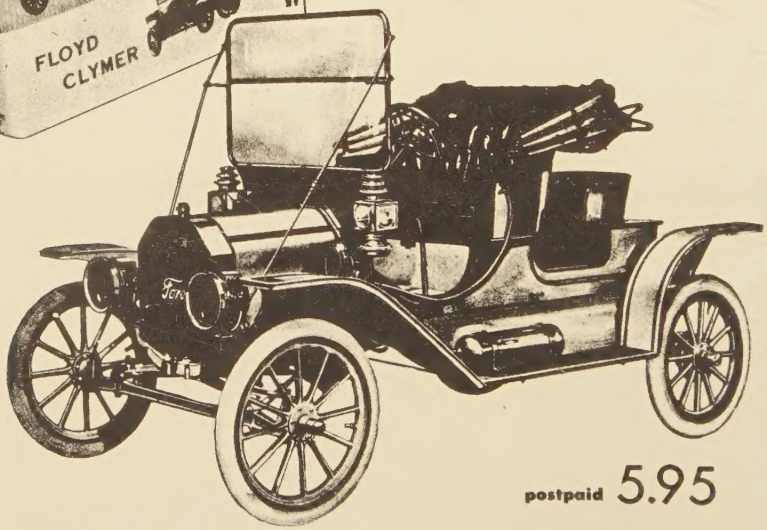

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BY

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CATALOG OF 1921 CARS

Included in this 240 page book are 87 makes of passenger cars and 51 makes of commercial vehicles. Along with the photos of each of the 220 different models shown are complete specifications and price lists. Included are such names as Anderson, Brewster, Commonwealth, Crow-Elkhart, Dixie-Flyer, Dodge, GMC, Hanson, Holmes, International, LaFayette, Lincoln, Oldsmobile, Piedmont, Pilot, Saxon, Stephens, Templar, United and Wilson. .....**Postpaid $3.00**

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This beautiful book of 230 pages has photos, complete specifications and price lists of 212 different models which include 78 makes of passenger cars and 47 makes of commercial vehicles. The trade names include Chandler, Cleveland, Commerce, Daniels, Diamond T, Dorris, Duplex, duPont, Durant, Earl, Flint, Lorraine, Milburn, Mack, Republic, Sayers, Selden, Sterling, Ward, Whippet and Wills Sainte Claire.
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CATALOG OF 1927 CARS

This book has photos and specifications of 80 passenger cars of 44 different makes. Included are such names as Auburn, Briscoe, Case, Diana, Essex, Flint, Gardner, Hupmobile, Jordan, Kissel, Locomobile, Marmon, Oakland, Peerless, Rickenbacker, Star and Willys-Knight. Other features include the formula used to determine the N.A.C.C. horsepower rating of motors of various sizes—a 48 page directory of automobile terms—a 24 page section of views from various automobile plants showing up-to-date mass production methods at that time. .....Postpaid $2.50

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This book of 188 pages has photos and specifications of 148 vehicles including passenger cars and buses, taxicabs and trucks. A few of the makes are Atterbury, Corbitt, Cunningham, Durant, Elcar, Federal, Graham-Paige, Kleiber, Larrabee, Moon, Pierce-Arrow, Roamer, Stutz, Stearns-Knight, Velie and Whippet. A six page table lists alphabetically the prices of all models of passenger cars—an amazing total of 580 different models and body styles Another section gives some interesting facts and figures relating to the automobile industry. .....Postpaid $2.50

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My Experiences With Ford Cars

By Floyd Clymer

AUTOMOBILE TOPICS/NOVEMBER, 1953

THE first Ford I ever saw was a Model A two-cylinder in 1904. The next one was at the Denver Automobile Show in 1906. At that time my father was a physician and surgeon in the small town of Berthoud, Colorado (population 1000). I was eleven years old and at that time a dealer for Reo, Maxwell and Cadillac cars.

It was not until a few weeks after the 1906 Denver Show that I felt the real sting of Ford competition.

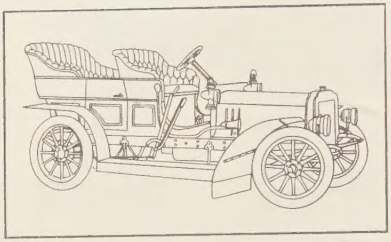
A local real estate man by the name of George Nall acquired the Ford agency in Berthoud and his first demonstrator was the Model N Roadster, the first really low priced 4-cylinder car. Henry Ford offered this model at $500, which at that time astounded the automotive world. Cars that I was handling like the one or two-cylinder Reo, the two-cylinder Maxwell, and the single cylinder Cadillac sold for $675 to $950. The lower priced Ford immediately cut into my sales, and Mr. Nall enjoyed a fair business until the Model T came out in 1908, and then his business really started to boom.

The little model N was faster than the Reo, Maxwell and Cadillac and I recall that the gear ratio in low was exceptionally high. It was a fast car in low gear. It had a top speed of about 40 miles an hour in high, and a few unusual features such as a folding device that held a starting crank in an upright position. The water pump, which quite often sprung a leak, was was located in front of the radiator. The transmission was two-speed planetary type.

Prior to the advent of the $500 Model N, Henry Ford was not quite sure just what he wanted to build. He built the first Model A, a two-cylinder car, in 1903. He also built a large four-cylinder car and the highest priced Ford was the large six-cylinder 1906 and 1907 Model K which sold for $2700, or approximately $2000 more than the single-cylinder Cadillac. Times certainly have changed!

After the advent of the Model T Ford, sales climbed at a rapid rate. In 1910 our family moved to Walla Walla, Washington and, after working for the Studebaker EMF dealer there for a few weeks, I decided that Ford offered better sales possibilities for a young and aggressive 15-year-old auto salesman. I therefore secured a job with Harold Dahlen of the Dahlen Ford agency. It was in a remodeled livery stable. I helped unload and service the first carload of Model T Fords to arrive in Walla Walla. It took us about a month to sell the carload of seven cars, and the slowest moving model of the bunch was a 2-passenger coupe. No one wanted a closed car surrounded by glass, which was them considered very dangerous in case of glass shattering in an accident. Even the side curtains in those days were of isinglass.

The only serious accident I ever had in an automobile happened one day when I was demonstrating a Model T to three or four actors and actresses working in a Walla Walla theater. I turned completely over in the car. While traveling about 40 miles an hour, I leaned over to adjust the carburetor,



Ford Model K 40 h.p. 6-cyl. touring. $2700.

which could be done on the Model T by moving a lever on the right side of the dashboard. The car hit a chuck hole and overturned. The Model T had a badly wrecked body, radiator, fenders and lamps. No one was injured, but I had a swollen neck for about a month. It took me a year to repay Mr. Dahlen for the damage. He considered my little jaunt a "joy ride" rather than a demonstration.

I recall one contest held between a Model T Ford and an air-cooled Franklin. This was a challenge race for a hill climb in the Blue Mountains near Walla Walla. R. P. Rice, then manager of the Ford branch in Seattle, easily won the contest, much to the surprise of many Franklin enthusiasts because Franklin was extremely popular in that region.

In 1911 we returned to northern Colorado and located at Loveland, a nice town of 6,000, at the foot of the Rocky Mountains. I made a deal with Charles K. Hendy, then manager of the Ford Motor Company branch in Denver, to handle Ford cars in Louisville, Colorado, which was located a short distance from Loveland. At Denver I met Henry Ford for the first time. He was an interesting man who was intrigued by my experience as a car dealer, even though I was only 16 years old when I met him. He suggested I would do better selling Ford cars than any other make. However, because of my age, the factory later on did not approve of the arrangement.

I was intensely interested in motorcycles about that time, so decided to go into the motorcycle business in Greeley, Colorado. In 1916 the Ford dealer in Greeley died and the local banker recommended me for a Ford dealership and said he would back me. Foolishly, I did not foresee the tremendous progress that was to be made by Henry Ford and I turned the offer down. I decided to stick with my Excelsior motorcycle distribution for Colorado, Wyoming and New Mexico. Ford established many assembly plants in various cities, including Denver.

As Ford sales boomed, I well recall the time that Ford offered a rebate to the purchaser of every Ford car, provided the company reached a certain total number of sales for the year. They did reach the total, and a rebate was given to every purchaser.

He consistently increased production and lowered prices and at one time the Ford chassis sold for as low as $290, and a roadster could be purchased for $340. During practically all of the years of Model T production cars were offered in one color only. His remark that the Ford purchaser could "have any color he wanted as long as it was black" became a well-known Ford saying. Henry Ford believed in keeping the sales price as low as possible and therefore Ford was slow to offer accessories which many owners wanted. As a result, hundreds of firms sprang up offering all types of knickknacks, gadgets, accessories and parts to sell to Model T owners. There were special water pumps, steering wheels, tires, locks, wheels, heat indicators, carburetors, mufflers, manifolds, overhead valve units, special bodies, windshields, gasoline tanks, oil line cleaners, transmission improvement devices, external brakes, foot throttles (Model T Ford had only a hand throttle), ignition systems, pistons, and in fact almost every conceivable kind of accessory. For years manufacturers of these specialties did an ex-

cellent business and even some body firms offered special "cut down" and racing roadster bodies. The Model T Ford accessory boom was similar to the "hot rod" trend of today.

Hopped up Model T Fords won many contests on road, hill and track, much to the disgust of the manufacturers, dealers and owners of much higher priced cars. In 1922 Noel Bullock of Oshkosh, Nebraska, in a cut down home-made Model T won the famous Pike's Peak Hill Climb, defeating cars which sold for three or four times as much money as the Model T. A purchaser of a Model T was assured of exceptional resale value, much higher, in fact, than any other make of car. In the early twenties the only firm that started to give Henry Ford much competition was Chevrolet, when they were aggressively pushing the sale of the Chevrolet "490" model.

About 1925 as progress continued, the Model T with its planetary transmission started losing its popularity. Henry Ford was always rather set in his ideas and, in spite of the pleas of dealers and some of his officials, including his son Edsel, for a new model, Mr. Ford was not prone to change. The pressure for a change continued and in 1927 Ford startled the world by closing down his factories and announcing that a new Model A, to be equipped with a sliding gear transmission, would soon be ready. It required many months for the changeover, due to Ford's peculiar manufacturing operations. As a result, many Ford dealers suffered severe financial reverses.

When the Model A did arrive, however, and was first displayed throughout the United States, show rooms were crowded day and night. I recall an unusual incident in Denver where I lived at the time. All Ford dealers were running "teaser ads" on the new Model A, which no one had seen, and the secret of its design was closely guarded. On a certain date in Denver, the new models were to be shown in all Ford dealer showrooms, and a used car dealer by the name of Harry Leeman nearly caused a riot when he announced the showing of a Model A Ford two days before the regular dealer displays were scheduled. Later developments showed that Leeman had gone East and in some manner secured a new Model A by paying a bonus to some small town dealer and trucked it to Denver under cover.

In 1921 I started building the Clymer windshield spotlight, which operated through a ball and socket joint through the windshield. My best customers were Ford dealers because of their tremendous business, and by then more than half the automobiles on the highways of the United States were Model T Fords. From then on I had little to do with Ford cars, until I started conducting the Owner's Poll and Test Reports on all makes of new automobiles for Popular Mechanics magazine in 1950. I have since road tested three different Ford models, and we have polled several thousand owners of Ford cars in all states, to secure their opinions of Ford models for Popular Mechanics.

Ford quality and reputation, as in the days of the early Model T and A, continued. In the opinion of the American motoring public, the reputation of Ford products is, as it has always been, extremely high. I find a very high percentage of satisfied Ford owners, as well as a high percentage of owners who say they will again buy a Ford product. In some of the surveys that we have made, we have found owners who have owned as many as 50 Ford cars, and it is not unusual to find many who have owned 20 to 30 cars of Ford manufacture.

AUTOMOBILE TOPICS, having been established three years before Henry Ford started building automobiles, is happy to salute the Ford Motor Company and to congratulate them upon the wonderful progress that they have made in the past fifty years.

Floyd Clymer

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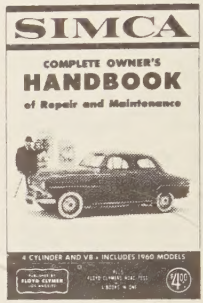

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A complete owner's handbook of maintenance and repair covering all models of Austin Healey Sprite and MG Midget. This new 300 page book includes tuneup data and assembly procedure on engine, gearbox and all components. Nearly 1000 photographs, charts and drawings clearly show step-by-step sequence of repair, renewal and fitting. An excellent 34 page section on tuning for better top speed and power is included, also a 60 page drivers handbook filled with valuable information. This book is a must for the owner who wants to keep his little jewel in tip-top operating condition to squeeze out its performance potential.

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This beautifully illustrated manual presents a score of never-published photos, charts and cutaways from the Ferrari Factory files among hundreds of illustrations. Complete specifications and data on the outstanding Ferrari Grand Prix, Touring and Sports models plus tuning and repair data that the average enthusiast and owner can understand. Hans Tanner, well known European correspondent has dug deep into factory material to compile this highly interesting volume that will appeal to all car fanciers as well as providing an heretofore unavailable source of information for the owner. Forward by Luigi Chinetti. Complete in 167 pages. .....**Postpaid $4.00**

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1962 INDIANAPOLIS "500" YEARBOOK

The 1962 Indianapolis 500 Yearbook, published by Floyd Clymer, 222 N. Virgil Ave., Los Angeles, is the largest and most profusely illustrated in the sixteen-year series of these histories. In a full 8½" by 11" format, the 1962 Yearbook has 192 pages and nearly five hundred photos, charts and drawings covering every aspect of the famous 500 mile race. In addition to a detailed resume of the race, minute by minute, the Yearbook includes full information on drivers, cars and conditions. A technical analysis of the entries, construction details and names of the builders of qualifying cars, driver and mechanic biographies, history, color and action around the Speedway are only a part of the fascinating wealth of detail contained in this book. A day-by-day account of the month of May, practice and qualifying; included; the history of the Meyer-Drake Offenhauser engine; Mickey Thompson's Indy challenge and what role Detroit may play in the future of the Speedway are additional interesting topics. Clymer's 1962 Indianapolis 500 Yearbook is the only publication of its kind and a "must" for every racing fan. Available from Floyd Clymer Publications, 222 N. Virgil Ave., Los Angeles 4, California for .....**$3.00 Postpaid**

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Hans Tanner, well known authority on International racing activity and technical developments of European competition vehicles, has prepared a handbook which should be of interest to every Grand Prix aficianado and one which should be a part of every collector's library. The "Handbook of Grand Prix Cars", details the construction of every make and type of Formula I automobile built from 1946 to 1962. Full specifications of engine and chassis are given on such rarities as AFM, Veritas, Simca Alta, Bugatti, Talbot and Cisitalia, plus the better known marques such as Lotus, BRM, Cooper and others. The histories of each of the constructors are set forth and complete competition records are included in a special section. Another feature of the book consists of maps of the world's leading circuits. Nearly 100 photos of cars and construction details are included in the 184 page volume which is available from Clymer Publications, 222 No. Virgil Ave., Los Angeles 4, Calif.....**$3.00 Postpaid**

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Announcement

This interesting and unique book on the Ford T, A and Fordson products was written by Victor W. Page, an early day automotive authority.

It was copyrighted in the years of 1915, 1916, 1917, 1918, 1920, 1923, 1926 and 1926, due to revisions from time to time that Henry Ford made in his famou Model T. Thus the book covers the fabulous years of the Model T popularity.

In 1928 when the Model A was first introduced Mr. Page again revised the book to cover the new Model A. Like the T, there were few basic differences in the Model A from year to year.

The book was published originally by the Norma W. Henley Co., from whom we purchased the plates and publishing rights in 1950.

Ford T and A owners, as well as collectors and enthusiasts, will find this book the most complete eve published on the two models. The Fordson Tractor is also well covered.

Henry Ford and his Models T and A will never die in the hearts of motor car enthusiasts the world over. Henry Ford certainly put the world on wheels.

Floyd Clymer

Publisher.

PREFACE

The enormous production facilities of the Ford Motor Co., Detroit, Mich., and the low price of the product, has created a situation unique in the industrial world. The Ford Model T car has been built with practically no important structural or mechanical change for fourteen years at this writing and over 12,000,000 Ford cars and trucks have been produced to meet the demand for this universally used motor vehicle. Most of these cars have been sold to and are being operated by persons in walks of life that cannot be expected to have expert mechanical or automotive knowledge. Many have had no previous experience with the gasoline engine as a power plant. The Fordson Farm and Industrial Tractor has been in large production for some time and several hundred thousands of this excellent machine are now in daily use and new fields of application are being opened up rapidly. In view of the world wide distribution, and the fact that these cars and tractors may give service to a number of owners before they finally wear out, this special treatise has been compiled for the instruction of car and tractor owners who may be interested in securing a comprehensive knowledge of repair and maintenance because they wish to service their own cars.

It was to meet the requests that were made by motorists for a book on the Ford car and Fordson Tractor that would enter into elementary exposition that this

book was first published in 1915. That it has met the need is evidenced by the fact that numerous editions have been necessary, and it has been revised and enlarged yearly to bring it down-to-date.

The writer feels that he was well fitted for compiling this treatise because he has owned, repaired and operated numerous Ford cars and has had many cars of that make under observation. This has made the collection of data from first hand sources possible. The co-operation of the Ford factory service experts has also been particularly valuable. Attention is directed to the numerous special photographs and drawings that have been made to illustrate this treatise so the subject matter would be easy of comprehension by the student and mechanically untrained Ford owner or driver. These illustrations will be found in no other treatise or manual.

The instructions given apply to the Ford car and Fordson Tractor as produced by the factory. It would require a special volume to consider all of the legion of accessories that have been produced to make real or fancied improvements in the car as originally designed so no attempt has been made to consider these.

This edition includes a description of the changes made in the Ford car for the coming season but these are more in the nature of detail refinements, so the instructions given apply, for the most part, to all Model T Ford cars that have ever been produced. An example to show the universal distribution of this product is that there are 20,000 officially recognized service stations for the Ford car and Tractor located all over the civilized world.

The complete description of the Fordson Farm and

Industrial Tractor included is through the courtesy of the service department of the manufacturer, which has furnished valuable information and illustrations and has helped to make the instructions given in this revision complete and authoritative and of greater value to the reader.

PREFACE TO MODEL A FORD CAR

The extremely large demand that existed for the Ford Model T Car and which resulted in the production of over 15,000,000 of these vehicles, of which it is stated over 8,000,000 are still in use in all parts of the world gives all indications of being duplicated in connection with the new Model A cars.

While extremely serviceable, the Model T did not seem to meet the requirements of a public that had become educated to the type of car that was being sold by all other car builders; i.e., it did not have modern body lines nor a sliding gear transmission.

The main Ford plants are now busily engaged in producing the new Model A and it is expected that by the end of 1928, there will be a very large daily output of these cars. For this reason, a supplement has been added to this volume, which describes the care and operation, as well as the main features of construction of the Ford Model A cars. Those interested in the sale or repair of Ford products will now have available one volume describing the old and the new that should be of benefit especially if one considers that direct comparison of differing features of construction is easily possible.

Victor W. Pagé.

August, 1928.

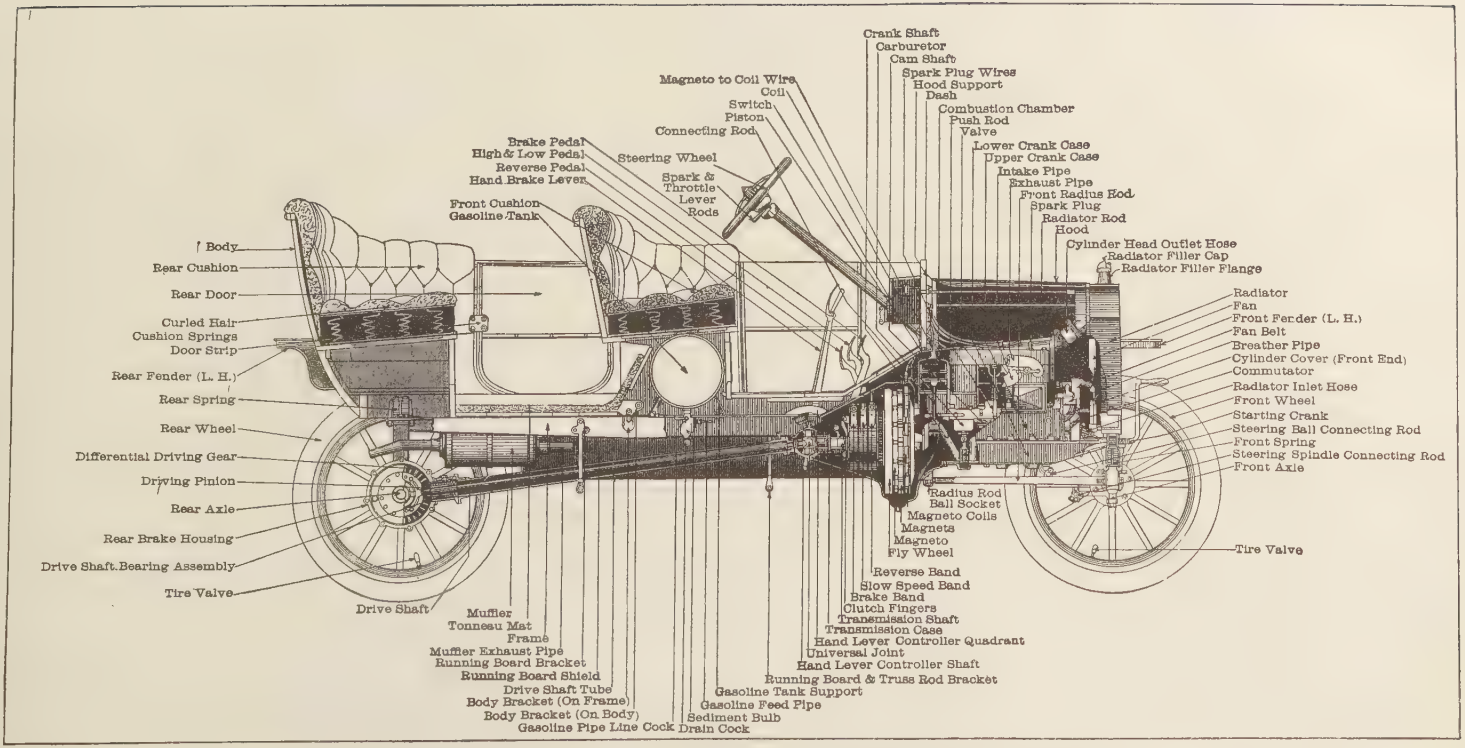

Fig. 2.—Sectional View of Ford Model T Touring Car Showing Construction of Chassis and Body Parts.

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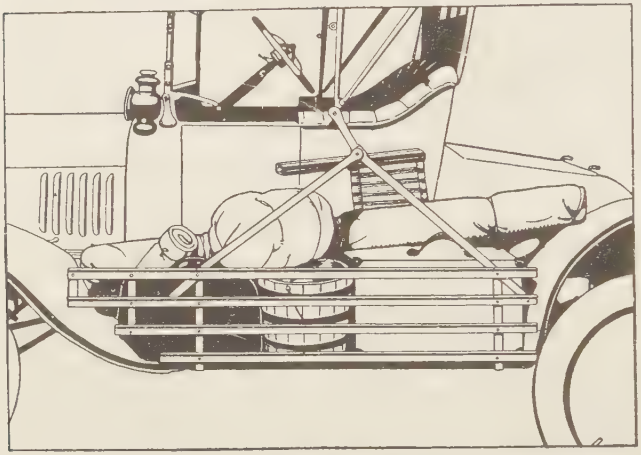
HANDY-PANDY LUGGAGE CARRIER



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THE FORD MODEL T CAR

CHAPTER I

THE FORD CAR, ITS PARTS AND THEIR FUNCTIONS

Important Components of Any Motor Car—Parts of Ford Automobile Chassis—The Ford Three Point Suspension System—Frame Assembly Details—Spring Construction—The Ford Body—The Ford Power Plant.

In order to have any subject easily understood by the layman, especially if it is a mechanical topic or one with which the public at large is not thoroughly familiar, it is always necessary to consider first of all the basic principles underlying the operation of the mechanism discussed. Those who are familiar with the subject to a degree may consider this matter superfluous because it is a review of things of which they already have some knowledge. The person who seeks information, especially the purchaser of an automobile who intends to operate it himself, in many cases does not have the slightest conception of mechanics. It is necessary to describe fully the various parts and how they operate and why they work as they do before any attempt is made to give suggestions for their care or operation.

In making repairs or looking for troubles the man who is familiar with the principles of action of the parts at fault is nearly always able to locate the trouble whereas those who are not posted on the methods of working are at a loss because they do not know where to start to look

for derangements. The automobile has been the greatest popular mechanical educator ever devised, but it is a much simpler and less expensive process to acquire this knowledge by becoming familiar with the experience of others instead of learning all the points involved by the slow and uncertain process of actual personal experience. In preparing this treatise the writer believes that it will have more value for most of those it is desired to instruct if the assumption is made that the reader knows absolutely nothing regarding automobile construction. For this reason, the exposition starts with a description of the parts that are absolutely necessary to secure successful operation of any self-propelled road vehicle, then various units of the car discussed are described and their functions outlined. Endeavor has been made to present the information in a clear manner and to avoid technicalities. It is desirable, however, that mechanical terms be used and all parts called by their correct names, ready identification being provided by clear, lettered illustrations.

Important Components of Any Motor Car.—In this era of progress, one would hesitate to assert that the motor car had been perfected or it had reached a finality in design, though the experience of the last few years would justify one assuming that the principles of construction now applied so successfully may reasonably be considered permanent. The elements which have been proven essential to insure successful operation of all self-propelled conveyances may be easily defined as follows:

First: The endeavor of modern constructors is to make all operating parts of such material, size and strength, that the severe strains imposed by the rough nature of the average road surface will be resisted adequately and

to secure endurance and serviceability under all possible conditions of operation.

Second: The mechanism should be as simple as it is possible to make it, as this promotes ease of repairing, facility in handling, and lessens the liability of trouble by reducing complication. The parts should be in proper proportion and arranged in such a manner relative to each other that one may be removed or replaced without disturbing other correlated appliances.

Third: The power furnished by the gasoline engine carried in the frame must be transmitted to the traction wheels or to the revolving shafts to which they are fastened with as little friction and power loss as is possible.

Fourth: The two driven wheels (preferably the rear ones) must be connected to some form of compensating or balance gear which enables each wheel to revolve independently of the other at times and at different velocities, because in turning corners the outer wheel describes a larger arc and consequently a longer path than the inner member. The differential gear was one of the most important elements which made for the successful development of the automobile.

Fifth: The steering should be done by the two front wheels which are carried at the ends of a yoke axle which is securely fastened to the chassis frame by means of the springs. The wheels are carried on steering knuckles which must be arranged to assume different angles when the vehicle is turning corners or deviates from a straight path in order to secure positive steering.

Sixth: Springs must be provided which will have sufficient strength and elasticity to neutralize vibration and allow for unevenness of the road surface by their yielding qualities and thus reduce body movement. In order to

relieve the machinery, running gear and passengers of the inevitable vibration which obtains at even moderate speed on ordinary roads, the wheels should be provided with very resilient tires, preferably of the pneumatic or inflated forms for pleasure cars, and cushion or solid rubber on the heavier and slower-moving motor trucks.

Seventh: The gas supply to the motor, the ignition of the charge, and the continuation of the cycle of engine operations should be automatic and require no attention from the operator after the motor is once started. To secure continued operation, mechanical means must be provided for constant lubrication of all moving parts. All components which have movement relative to other parts should move with as little power loss by friction as possible, in order to conserve the available motor energy for tractive purposes. Anti-friction bearings of the ball or roller type should be employed on all rotating shafts in the power plant, transmission system, and in the wheels to save power.

Eighth: The center of gravity must be carried relatively low, which involves placing the body as close to the ground as practical considerations will permit. The wheel base, which is the distance between front and rear wheel centers, should be long, in order to secure the best result in tractive effort, steering and comfortable riding. The power plant and other essential mechanism should be carried on a frame which will be supported in such a manner that road shocks will not be transmitted to them and so coupled together that no frame distortion will produce disalignment of the driving shafts.

Ninth: The control elements must be designed with a view to easy handling. This means that the steering gear should be practically irreversible—i.e., the hand wheel

should not be affected by side movement of the front wheels, thus relieving the driver's arms of all undue strain while driving. Motor regulation should be by levers placed convenient to the driver's hands or feet, and gear shifting should be accomplished without difficulty. Powerful brakes must be employed to insure positive check of vehicle motion whenever it is desired to bring the conveyance to a stop. It is evident that the levers through which the brakes are operated should be so proportioned that a minimum of effort on the part of the operator will serve to check the vehicle immediately.

Parts of Ford Automobile Chassis.—A brief explanation of the function of each part of the Ford gasoline car chassis depicted at Figs. 1 and 2 will serve to afford a better understanding of the construction of an automobile. The purpose of the front axle is not unlike that of a horse-drawn vehicle, but it is much different in construction. The wheels are installed on movable spindles, or steering knuckles, which are supported by yokes permitting one to move the wheels for steering rather than turning the entire axle on a fifth wheel, or jack-bolt arrangement, as in a horse-drawn vehicle. This axle is attached to the frame by spring member which allows a certain degree of movement without producing corresponding motion of the frame. The radiator, which is placed directly over the axle in front of the motor, is employed to hold the water used in keeping the engine cool, and is an important part of the heat-radiating system. The starting handle is a crank by which the motor crank shaft is given sufficient initial movement by the operator to carry the engine parts through one or more portions of the cycle of operations, this starting the engine. The tiebar joins the arms of the steering spindles on which the

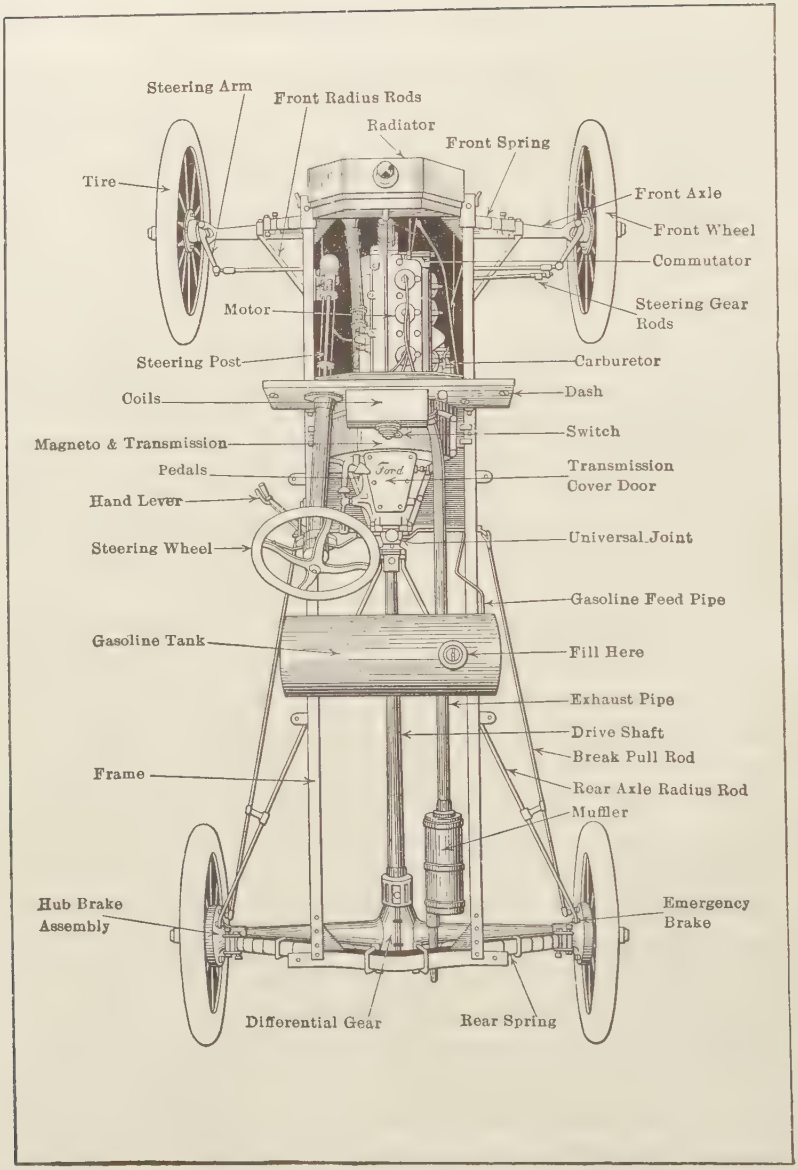

Fig. 1.—Plan View of the Ford Chassis Showing Relative Location of Important Components.

wheels revolve, and insures that these will swing together and in the same direction, either to the right or left. The steering link, often called the "drag link," connects one of the steering knuckles of the front axle with the steering gear.

The motor is a four-cylinder four-cycle type, to be described in proper sequence. The dash is a wooden partition placed back of the power plant to separate the engine space from the seating compartment. It is employed to support some of the auxiliary apparatus necessary to motor action or some of the control elements. The clutch is a device operated by a pedal, which permits the motor power to be coupled to the gearset, and from thence to the driving wheels, or interrupted at the will of the operator. It is used in starting and stopping the car, and whenever the speed is changed. The pedals are foot-operated levers, one of which releases the clutch and applies the slow speed; one is used to reverse the car, the other applies the running brake on the transmission. The motor control levers on the steering column are used in conjunction to vary the rotative speed of the motor, and thus regulate the energy produced in proportion to the work to be performed. The emergency brake lever applies a powerful braking effect when it is desired to stop the car quickly, and also when one wishes to lock the brakes if the car movement is arrested on a down grade. The steering wheel actuates the mechanism which moves the wheels to the right or left when one wishes to describe the circle, turn a corner, or otherwise deviate from a straight line.

The change speed gear is one of the most important elements of the power transmission system, and in connection with the clutch it is much used in operating and

controlling the vehicle. The function of the frame has been previously described. The exhaust pipe is employed to convey the inert gases discharged from the motor cylinders to a device known as the muffler, which is designed to reduce gas pressure by augmenting the volume, and thus diminish the noise made as it issues to the atmosphere. The driving shaft transmits power from the change speed gearset to the bevel gearing in the rear axle. A universal joint is a positive connection which permits a certain degree of movement between two shafts which must be driven at the same speed. One or the other, or both, may move in a lateral or vertical plane to a limited extent without interrupting the drive or cramping the moving parts. The rear construction houses the differential and driving gears, and the shafts or axles which transmit the power to the traction wheels.

Brakes are used to retard, or stop the movement of the wheels, and are operated by rods which transmit the force the operator applies at the brake pedal or hand lever to the brake bands. Torque members or radius rods are used to maintain a definite relation between the driving gears in the axle and those in gearset, and to take the driving thrusts off the axle and the strains imposed by braking and driving from the springs. The principles underlying operation of each of the parts shown and the number of different forms in which they may exist, will be described more extensively in the chapters dealing with the various groups.

The Ford Three Point Suspension.—In order to permit the sale of cars of good quality at moderate prices it is necessary that the design be simplified to a point where assembly cost during processes incidental to manufacture will be kept at a minimum. This elimination of unneces-

sary parts and the endeavor to simplify the assembly in order to reduce manufacturing expense really acts in favor of the purchaser because it is easier to maintain, operate and repair a simple car than one having a greater number of parts and more complicated mechanism. In the design of the Ford chassis the main points attained have been simplicity and lightness without sacrifice of strength or endurance. The Ford car may be said to consist of four really essential groups, each of which is supported or joined to the other members by a three point suspension system. These component parts are the front axle group, the power plant assembly, the rear axle group and the frame.

The method of supporting the power plant by three points is clearly shown at Fig. 5, as is also the system of attaching the rear axle to the frame. A direct front view of the chassis at Fig. 6 shows the front axle construction and the method of supporting the front end of the frame. A direct rear view of the stripped chassis shown at Fig. 7 outlines the method of supporting the frame by a single cross spring of peculiar form and taken in conjunction with the plan view at Fig. 5, shows clearly the method of installing the rear axle to obtain a three point suspension of this member as well. There is a sound engineering reason for the three point system which is now widely followed in many automobiles. In the first automobiles, and in fact in many of the cars built to-day, the four point suspension system is followed in supporting the power plant to the frame. With the four point construction the power plant is provided with four supporting arms usually cast integrally with the engine base, two of these being on each side of the crank case. They are usually of such length that they can be

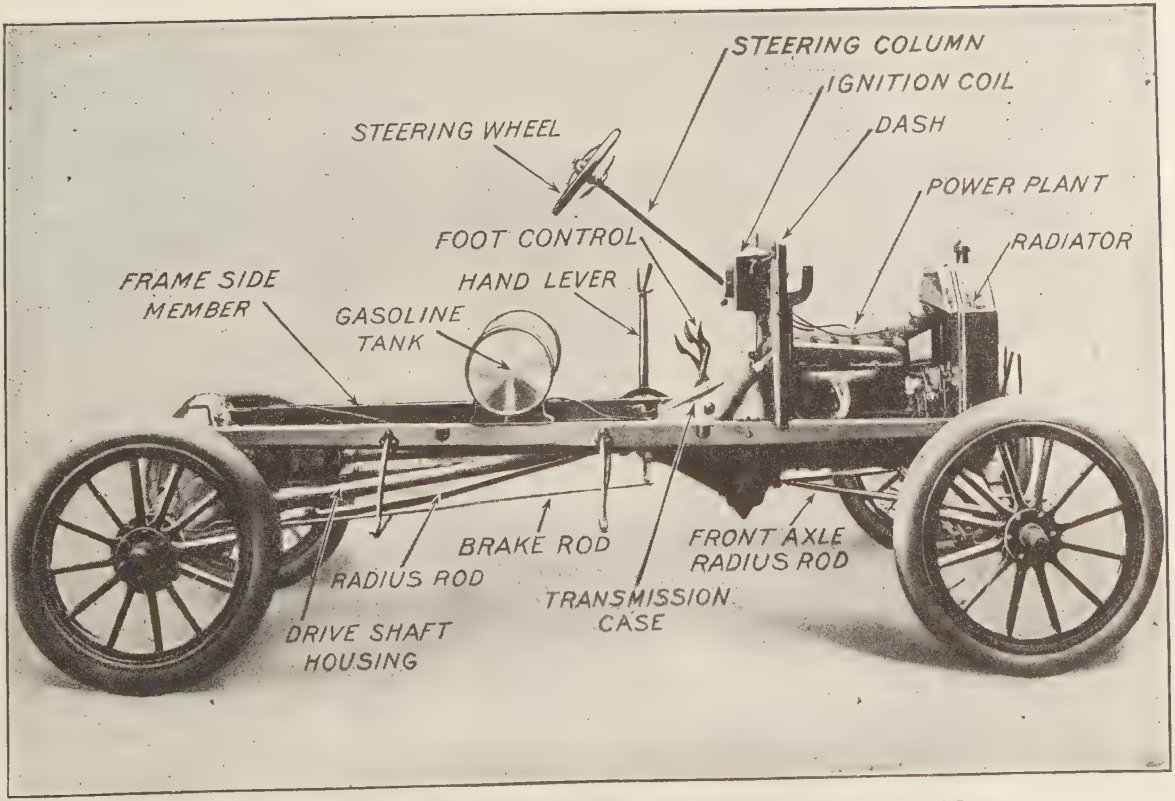

Fig. 3.—Side View of Stripped Ford Chassis Showing Valve Side of Motor.

bolted to the frame side member or rest on suitable supporting brackets riveted to the frame side or carried by the sub-frame. This makes a very rigid construction when the bolts are tightened down and the engine bed firmly secured to the frame. While this method of support is very strong, it has the disadvantage of resisting any tendency of the frame twisting when the car is operated on unfavorable highway surfaces or when some one of the wheels passes over an obstruction or drops into a hollow in the road. These twisting strains stress the crank case arms and very often will break them off.

It was to eliminate this that the three point suspension was invented. The four point suspension is found in most cases in cars where the engine is a separate member from the change speed gearing. Where the change speed mechanism is incorporated as a portion of the power plant, as is true of the Ford construction, it is possible to suspend the engine on three points, as shown at Fig. 5. The first point is at the front end of the motor and consists of a turned cylindrical bearing resting in a trunnion block carried by the front cross member. The second and third points are provided by supporting brackets or arms of pressed steel which are securely riveted and brazed to each side of the flywheel housing. These arms rest upon the frame side member and are rigidly secured to the frame rail by bolts and lock nuts. Wooden blocks are placed between the frame side channels and one bolt passes through the wood block horizontally, while another passes through the top and bottom of the frame side member vertically.

There is some difference in construction between the two points of support attached to the flywheel housing and the single or first point of support at the front end

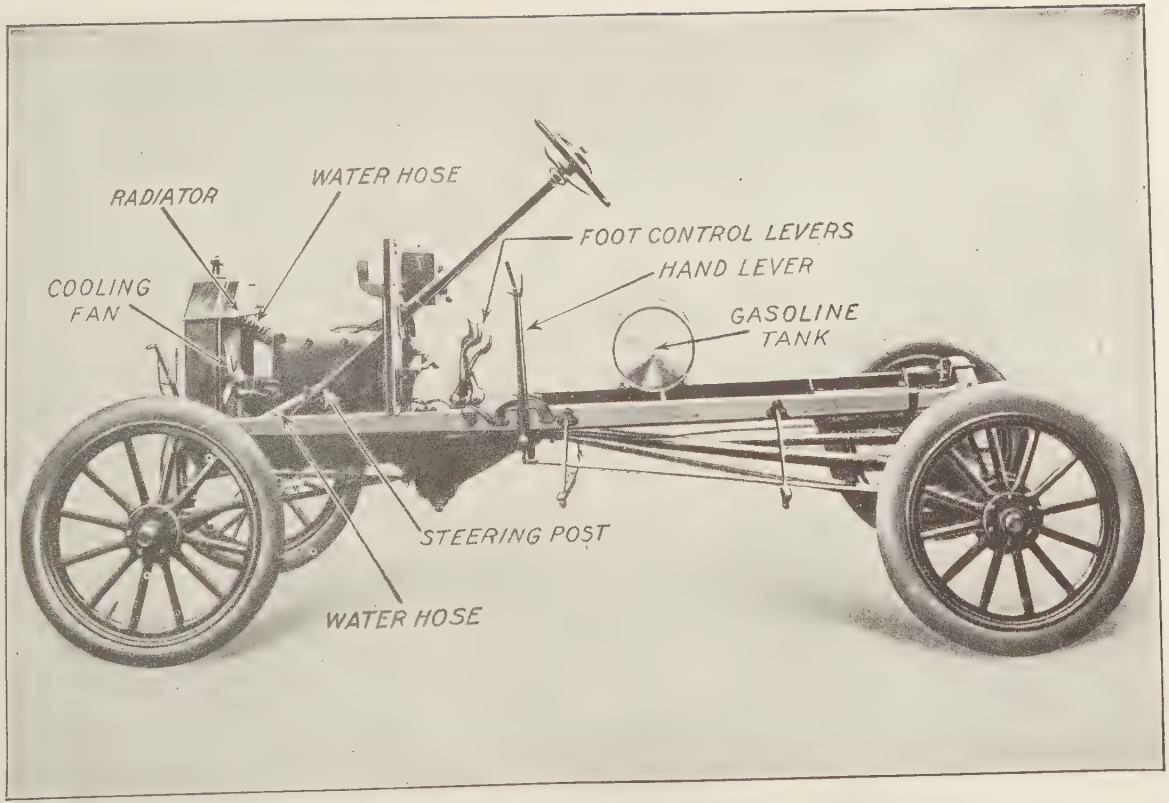

Fig. 4.—Control Side of Stripped Ford Model T Chassis.

of the engine. While this holds the motor firmly in place, it permits a certain rocking action or movement of either front corner of the frame without likewise affecting the power plant. The front end bearing rests in a trunnion box made with a cap much in the same manner as one of the main crank shaft bearings of the engine. This is made in two sections, the lower or bed section being bolted to the front cross member of the frame, while the upper half, which is removable when it is desired to take out the power plant, is called the crank case front bearing cap, and is bolted to the lower member. By having a trunnion joint the twist imparted to the frame by inequalities of the road surface are not conveyed to the crank case as with a four point extension. For example, if the right wheel is raised six inches and the left wheel drops to the same amount, there will be a difference in level of one foot between them. This condition often obtains when driving a car on rutty roads, and in this case the front cross member of the frame moves on the crank case bearing, but does not twist the motor to any extent from its normal horizontal position.

The front axle is also supported at three points, two of these, which are shown in Fig. 6, being to the front spring by means of shackle links attached to suitable forged hanger members bolted to the axle. This makes two points of support for the front spring. As the cross spring is not of such construction that it will push the front axle as do the semi-elliptic springs used in cars of conventional design which are placed on each side of the frame running parallel to the frame side member, and having the axle fastened at their centers; it is necessary to provide a radius or push rod construction which is in the form of a V-shaped member of steel tubing terminat-

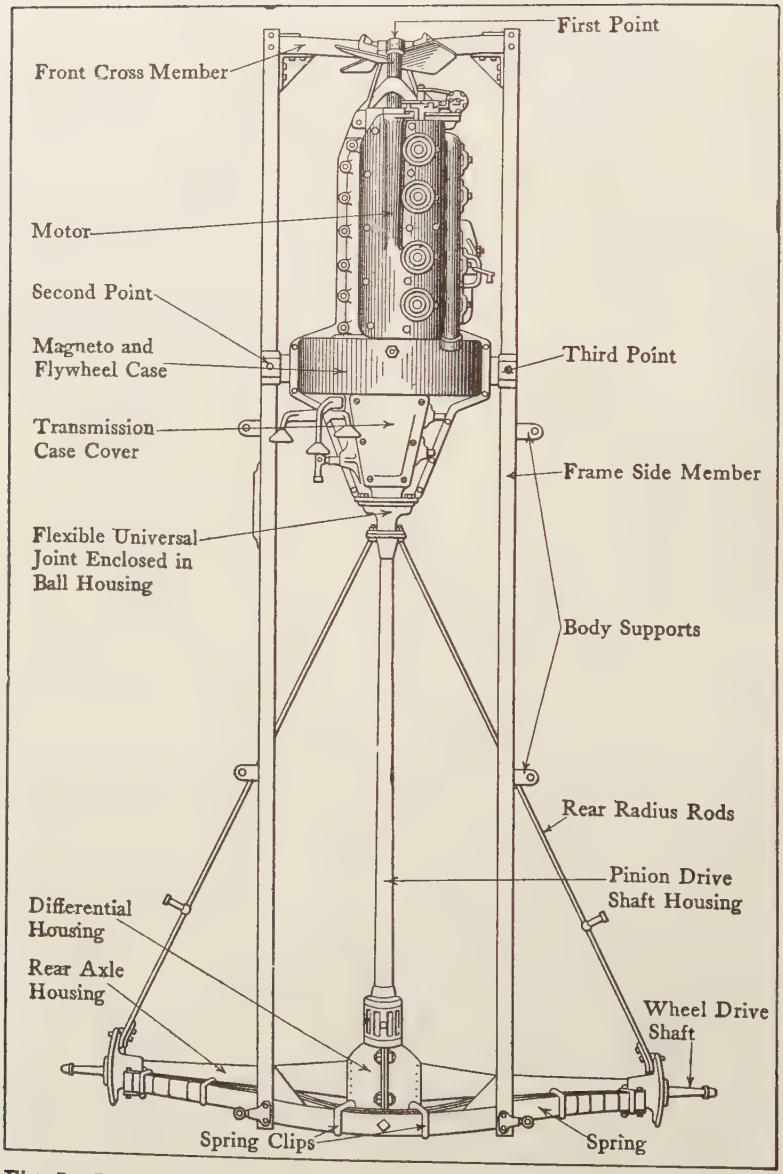

Fig. 5.—Plan View of Ford Frame with Power Plant and Rear Axle in Place Showing Three Point Suspension Principle Utilized in This Design.

ing in a ball at its apex and attached to the front spring supporting members at its ends. This triangular radius member serves to take the push of the chassis and move the axle forward as the car is driven in that direction. The ball rests in a socket member attached to the lower part of the flywheel casing of the engine as clearly shown at Fig. 3. It will be apparent that this method of support permits the front axle to move up or down or for one end to be higher than the other without tending to twist the frame as much as would be the case if the usual system of semi-elliptic front springs was used. A certain amount of twisting is unavoidable so the front axle three point suspension in connection with that of the motor insures that no strains will come on the crank case because of this varying frame distortion.

The rear axle assembly which also includes the driving shaft and its supporting housing is also fastened to the frame by three points. Two of these are at the axle where the single rear spring member is shackled to drop-forged steel hangers secured to brake shoe retaining plates while the third point of support is at a ball joint member attached to the rear of the transmission case. This ball joint serves to enclose the universal joint and performs the same function for the rear end of the car that the ball joint on the front end of the flywheel case performs for the front end of the car. The rear radius rod system is also triangular in shape, the rod members extending from the brake carrying castings on the ends of the axles to the flange fitting just back of the casting forming the ball part of the joint at the front end of the pinion drive shaft housing. This construction is clearly outlined in sectional view of the complete car shown on folding plate Fig. 2, and also in the plan view, Fig. 5. It will be apparent that

this three point support of the front axle, the power plant and the rear axle makes for a construction of great flexibility which combines the very desirable element of strength and endurance without the undesirable one of excessive weight. The lightness and ability of the frame

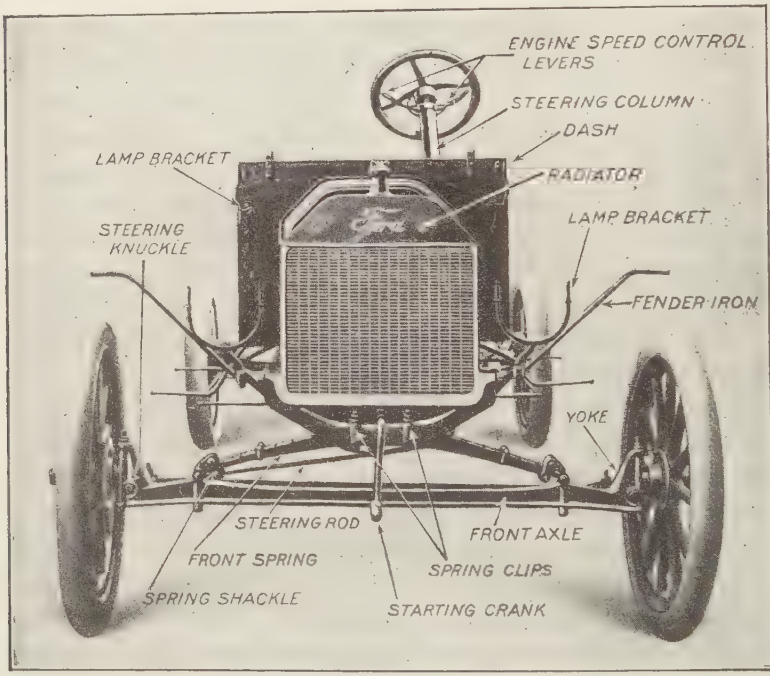

Fig. 6.—Front View of Ford Chassis Showing Front Axle and Spring Suspension.

and chassis mechanism to endure under the twists and strains incidental to rough road work has made the Ford car a practical conveyance for unfavorable, as well as favorable, road conditions, and enhances the comfort of the occupants under all conditions. As an assembling propo-

sition the three point suspension system is one that lends itself readily to quantity production, and if it is easily put together it is equally true that taking it apart will offer no difficulty. For example, if it is desired to remove the rear axle or the front axle from the Ford chassis the first step is to undo the ball and socket joint at the end of the radius rod and to remove one half of each spring shackle in the case of the front axle, this setting it entirely free and permitting its easy withdrawal. In addition to undoing the front ball housing at the end of the pinion drive shaft housing of the rear axle and the spring shackle member it is also necessary to uncouple the brake rods operating the rear wheel brakes at the point where they attach to the cross shaft actuated by the hand lever clearly shown in Fig. 1.

Frame Assembly Details.—The frame of the Ford car is a very simple member, and owing to the three point system of attachment of components is made light and flexible to a degree. It consists essentially of two long straight side members and front and rear cross members. The material used for the side members is a channel section pressed steel, the frame side rails being about 100 inches long. The cross members are not straight, as is the case of the side members, but are bent as indicated in Figs. 6 and 7. The front cross member is bent down to offer a support for the simple semi-elliptic cross spring while the rear member has an upward bend to fit the arch of the rear spring. The corners of the frame are securely braced by gusset plates or re-enforcing brackets, as indicated in Fig. 5. These are securely riveted to the frame side and cross members, the cross members also being attached to the side rails by hot riveting. Body supporting brackets are attached to the side rails to which the body

portion is fastened by means of bolts. These are held in place by riveting, as are the running board supporting irons.

Spring Construction.—The first point that strikes the person examining the Ford car carefully for the first

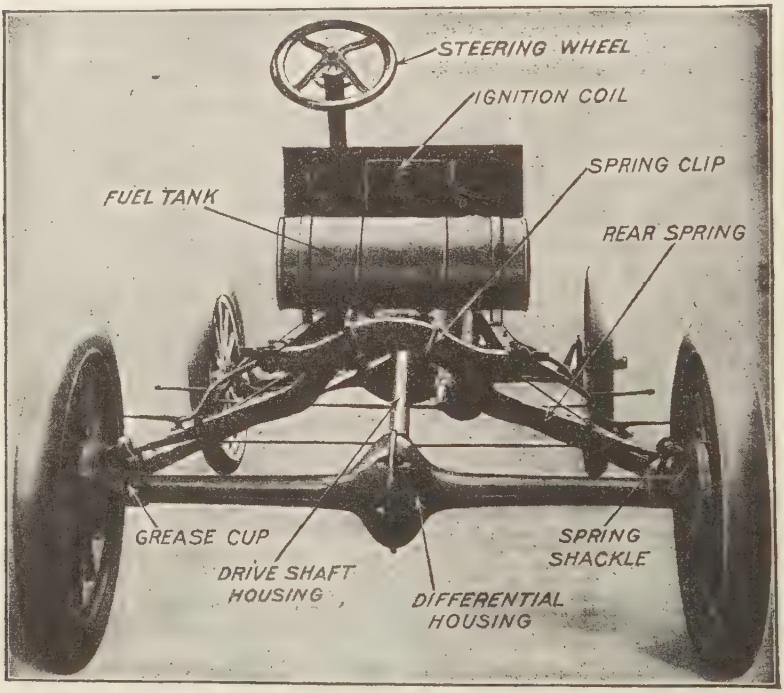

Fig. 7.—Rear View of Ford Model T Chassis Depicting Method of Attaching Rear Construction to Frame.

time, and one which serves as a ready means of identification, is the method of springing employed which is unconventional, though exceedingly practical. The springs of practically all automobiles are of the laminated type and are a built-up construction composed of long, flat sec-

tions of tempered high carbon or alloy steel that are called "leaves." The material used in the Ford springs is vanadium steel, an alloy which is said to possess greater endurance to continual deflection and rebound than ordinary high carbon steel. The Ford front spring is a semi-elliptic member, which term is applied to the spring according to the arc of an ellipse in which they are formed. A full elliptic spring would be one composed of two semi-elliptic members placed in such relation that they would produce a flattened circle or ellipse. A spring which is composed of one-half of a full elliptic member is called a semi-elliptic spring.

In common practice the center portion of the semi-elliptic spring rests on the axle of the car, the front end or eye being secured to the spring horn by a bolt while the rear end is attached to the frame by a shackle or hinge joint which is necessary to provide for the lengthening of the spring as it deflects under load, the tendency of the load being to straighten out the arch. In the Ford car the eyes of the front spring are shackled to the hangers on the front axle while the center portion is securely held inside of the channel section of the front frame cross member by means of U-shaped spring clips. This means that the semi-elliptic spring is inverted from the position it usually occupies on other cars. The front springs consist of seven leaves or laminations of graduated length, the longest being at the bottom and having eye members formed at each end, the shortest leaf being placed at the top. The seven leaves are held together by a tie bolt passing through their centers, which keeps the spring in shape whenever it is desired to unloosen the spring clips to remove it from the frame. Rebound clips are also provided to keep the spring leaves from spreading apart

under violent upward throw of the chassis frame. In order not to restrict free movement of the spring both front and rear shackles are provided with oil cups so that the shackle bolts may be kept properly lubricated at all times. It will be apparent, however, that spring movement must necessarily be limited, and that the more resilient a spring is the greater the degree of movement. The springs are constantly in action when the vehicle is used, and practically all of the comfort of the occupants is dependent upon them.

The rear spring shown at Fig. 7 is also a cross member, but it is not of the same semi-elliptic form the front spring is. It has a decided arch at its center, designed to conform to the arched portion of the rear cross member, to which the center of the rear spring is secured by substantial spring clips. The spring perches or hangers are drop forgings similar in form to the front members, and have a boss pierced with a hole through which the bolt of the spring hanger or shackle member passes. The Ford rear spring perches are securely held in the brake retaining plate castings at the ends of the axle.

The Ford Body.—Practically the only part of an automobile that resembles in any way the horse-drawn vehicles they supercede is the body or carriage work portion employed for conveying the passengers. The body of the Ford car is clearly shown at Fig. 2. The sectional view gives an idea of the tufted upholstery and the method of constructing the seat cushions. The body is usually composed of a framework of wood, to which formed steel sheets are fastened, these being termed panels. By the development of large stamping presses it is possible to form the entire panel of a rear seat member, for instance, out of a single sheet of steel so that practically no fitting

is necessary except to fasten it securely to the frame by means of small screws or nails. The wooden frame members serve as supports for the floor boards, and also for the seat cushions. The doors by which the front or rear compartments are reached are light wooden framework covered with sheet metal and secured to the main body frame by simple hinges. The upholstering of the Ford car is a fabric made in imitation of leather, which is tufted and filled with curled hair in the fashion of regular carriage upholstery.

The seat cushions are provided with a large number of coiled springs which are intended to support the passenger's weight and to supplement the action of the harsher-acting, stiffer chassis-supporting springs. These spiral springs absorb many of the minor shocks which would interfere with the comfort of the passengers if no springs were provided. It will be apparent that the passenger has three independent resilient supporting members between his body and the road. The pneumatic tires on the wheels form the primary shock-absorbing members, while the chassis springs are the secondary shock-absorbing members. The seat cushion springs and the curled hair padding are the final check against road vibration. In the Ford body the front floor boards are entirely removable, if desired, in order to gain access to the change speed gearing and the universal joint casing which are immediately under them. When the front seat cushion is lifted out, a hinged door permits of reaching the gasoline tank for filling. Lifting the rear cushion discloses another hinged door which provides communication to a compartment extending the full width of the rear seat suitable for carrying tools, supplies and various articles of equipment. The windshield and top are not shown in

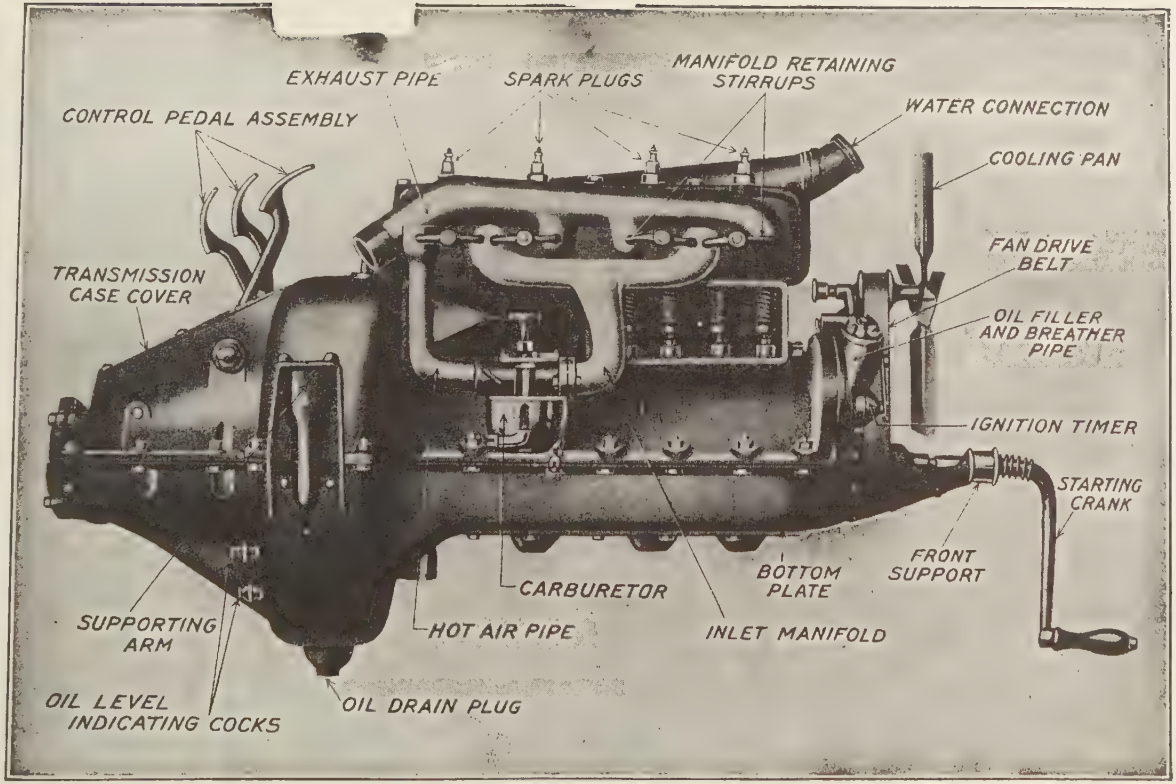

Fig. 8.—Valve Side of the Ford Model T Unit Power Plant Showing Manifolds, Carburetor and Interior of One of the Valve Spring Chambers.

illustration, though these are fastened to the body member. The sills of the body are provided with brackets of pressed steel, which are securely bolted to the wood and which rest on the body supporting brackets riveted to the car frame. The front end of the body is attached to the dashboard by angle irons. When it is desired to give the chassis a thorough overhauling it is not difficult to remove the body by loosening all of the body-retaining bolts, also the members holding the body to the dashboard assembly, which remains on the frame after the body is taken off.

The Ford Power Plant.—The motive power of the Ford car consist of what is known as a "unit power plant," incorporating the engine or power-producing member and the change speed gearing and clutch or power transmitting member. A side view of the engine is shown at Fig. 8, this showing clearly the parts that are readily discernible from the outside. The engine is a four-cylinder type, having the cylinders cast in one block which is integral with the top half of the engine crank case. As all the valves are on one side of the cylinder, it is known as an "L block" construction. The bore of the cylinder is 3¾", the stroke of the piston is 4". The engine is capable of attaining high rotative speed and will develop well over 20 h. p.

The advantage of including the change speed gearing and clutch in a unit with the engine is that there is no danger of loss of alignment of these members due to frame distortion as is possible when the power-producing and transmission elements are separate units, each having its independent means of support. The parts of the Ford power plant assembly are lined up properly when the engine is built, and there is no possibility of loss of

this alignment until the engine has been in service a long enough time so that the bearings wear and permit the parts to get out of line. Long before this lack of alignment becomes serious the motorist will be warned that the bearings require refitting by noisy action of the power plant or change speed gearing.

The power plant, as shown, while complete in itself would not be operative unless a number of auxiliary mechanisms and devices are provided. In order to insure engine action it is necessary to supply the cylinders with a combustible gas, which is done by the carburetion system. The gas must be exploded in the cylinder to produce power, which is the function of the ignition group. In order to keep the engine at the proper working temperature and reduce internal friction, lubrication means must be provided, while a water-cooling system prevents the cylinders and combustion head from overheating. The basic principles of engine operation, also those underlying the action of the auxiliary groups, will be fully described in proper sequence.

CHAPTER II

THE ENGINE AND AUXILIARY GROUPS

How the Engine Works—Engine Parts and Their Functions—The Fuel Supply System—Principles of Carburetion Outlined—Utility of Gasoline Strainer—What the Carburetor Should Do—The Ford Float Feed Carburetor—The Ford Ignition System—Induction Coil System Action Explained—Why a Magneto Is Used on the Ford—Wiring Dry Cell Batteries—Master Vibrator Systems—Why Cooling Systems Are Necessary—Cooling Systems Generally Used—Ford Water Circulation Methods—Theory of Lubrication—Derivation of Lubricants—How Ford Power Plant is Lubricated—The Ford Muffler.

The principles of action of all internal combustion engines are easily understood if one compares the effect produced by the explosion of the gas in the interior of the engine with the known effect obtained by firing any other explosive, such as gunpowder. Gasoline when mixed with air and compressed is highly explosive, and can be easily ignited by an electric spark. An explosion results from violent expansion which occurs where confined gases are fired. Combustion may exist in a number of different states, slow combustion, as the rotting of wood or rusting of iron; fast combustion, such as the burning of wood, coal or other fuels, and instantaneous combustion, which is that produced by igniting gunpowder or other explosives.

The manner in which a compressed gas can be made to give power may be easily understood by using as an illustration the difference between the noise of a firecracker that is in good condition and the "fizz" which results when an unexploded fire cracker is cracked open

by an economical child and the gunpowder thus exposed is ignited. The reason we have noise when the fire cracker explodes is because the rapid combustion of the gunpowder in the confined spaces of the firecracker interior bursts the containing walls and produces a loud noise. In other words, the gunpowder has been compacted or compressed to a degree before ignition. When the powder is lighted in the firecracker that has been broken open, there is no noise to speak of because there is nothing to restrain the gases produced by burning the powder.

Another illustration that simplifies the method of operation of a gas engine is to compare it with a muzzle-loading gun or cannon. After the charge of gunpowder is introduced at the open end of the barrel it is necessary to ram this tightly in place in order to compact it before the shot is introduced. After the fuse is lighted or firing-pin depressed the powder explodes with great energy and as the parts of the gun barrel surrounding the combustion chamber are sufficiently strong to withstand the force of the explosion, the movable member or shot is violently ejected from the gun barrel. If the same amount of gunpowder used to charge the gun was placed on a piece of paper and set afire, the only result would be a sudden flash or flame that would not be accompanied by an explosion, nor would it have any appreciable force because the gases are not confined.

In any internal combustion engine the gas charge is first drawn into a cylinder, which may be compared with the barrel of a gun by the suction effect of a downwardly moving piston member, and when the piston has reached the limit of its travel in one direction its motion is reversed and it moves back and starts to compress the gas previously inspired. As soon as the gas is properly com-

pressed, which means that its volume has been reduced and its pressure increased, an electric spark takes place in the interior of the combustion chamber and the resulting explosion of the gas sends the piston violently downward, and this motion, through the medium of a connecting rod, imparts a rotary movement to a crank member.

The difference between an internal combustion engine and an external combustion engine is easily understood if one knows that the steam engine operates on the latter principle. With the steam engine, power is derived by admitting steam to the cylinder, which is obtained from a separate boiler member. This is produced by the evaporation of water by a fire under the boiler. It is evident that the power is really obtained by the combustion of fuel, the steam being only a flexible medium that has transformed the heat of the fire into the power. The steam bears against a movable piston member in the steam engine cylinder, and the movement of the piston is transformed into mechanical energy at the crank shaft in the same manner as in a gas engine. Wherever the fuel is burnt directly in the cylinder instead of under another part of the power plant so that its heat may be expended directly to produce piston movement with minimum power loss, the engine is called an "internal combustion engine."

How All Automobile Engines Work.—It is evident that burning powder in the air will produce a certain amount of energy, but as the explosion takes place in the open there will be nothing to restrain the pressure, and just as soon as the powder is lighted, any energy evolved by the combustion is dissipated into the atmosphere instead of the force being directed against a yielding member such as a shot. This bullet is forced out of the gun barrel, not

only by the gas pressure which results as soon as the powder is exploded, but also by the expansion of the gases generated by combustion which tends to accelerate its motion toward the open end of the barrel. As the shot moves toward the end and the gas occupies more space its pressure becomes less, and when the ball leaves the mouth of the gun there is very little power remaining in the moving gas. There is sufficient pressure, however, so that the gas rushes out of the interior and the barrel is thus cleared of inert products which have no more useful force. The action of a modern repeating rifle is somewhat different than that of a muzzle-loader, because the powder is already compressed in metal shells which are introduced at the breech of the gun instead of at the muzzle. A number of shells are carried in a magazine, and after one of these explodes the recoil due to the explosion of the gas supplies another charged shell to the breech and the operation of firing the gun may be repeated as long as the supply of ammunition in the magazine lasts.

The modern four-cycle gasoline engine follows the action of both the old type muzzle-loader and the more modern form in which the shell is introduced at the breech. Referring to sketches at Fig. 9, we can compare the action of a simple four-stroke engine with that of a gun. The principal elements of a gas engine shown are not difficult to identify, and their functions are easily defined. In place of the barrel of the gun one has a smoothly machined cylinder in which a movable barrel-shaped element fitting the bore closely may be likened to a bullet or shot. It differs in an important respect, however, as while the shot is discharged from the mouth of the gun the piston member sliding inside of the cylinder

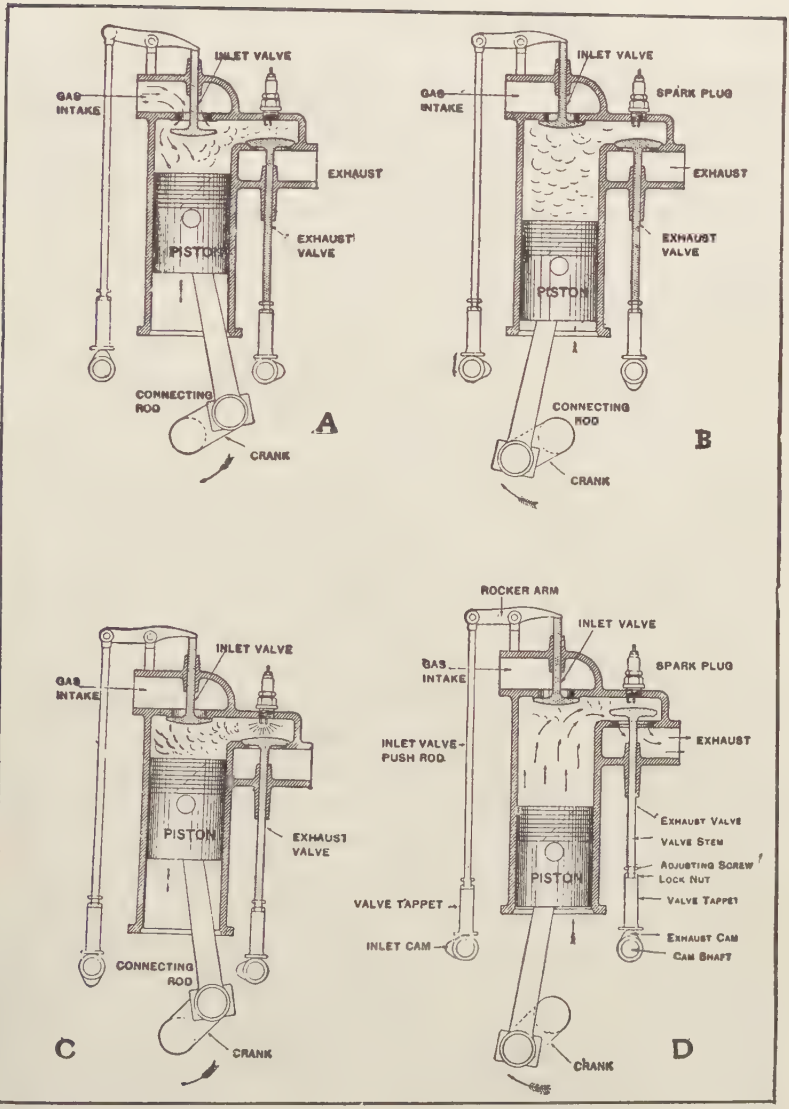

Fig. 9.—Simple Diagrams Showing the Various Cycles of Operation Necessary to Obtain an Explosion in the Four Stroke Gasoline Engine Cylinder. A—Suction. B—Compression. C—Expansion. D—Exhaust.

cannot leave it, as its movements back and forth from the open to the closed end, and back again, are limited by simple mechanical connection or linkage which comprises a crank and connecting rod. It is by this means that the reciprocating movement of the piston is transformed into a rotary motion of the crank shaft. The flywheel is a heavy member attached to the crank shaft which has energy stored in its rim as it revolves, and the momentum of this revolving mass tends to equalize the intermittent pushes on the piston head produced by the succeeding explosions of gasoline vapor in the cylinder. If any explosive is placed in the chamber formed between the piston and closed end of the cylinder and exploded, the piston would be the only part that would yield to the pressure which would produce a downward movement. As the piston is forced down, the crank shaft is turned by the connecting rod. This part is hinged at both ends, so it is free to oscillate as the crank turns, and thus the piston may slide back and forth, while the crank shaft is rotating or describing a curvilinear path.

In addition to the simple elements described it is evident that a gasoline engine must have other parts. The most important of these are the valves, of which there are two to each cylinder. One closes the passage connecting to the gas supply and opens during one stroke of the piston in order to let the explosive gas into the combustion chamber. The other member, or exhaust valve, serves as a cover for the opening through which the burnt gases can leave the cylinder after their work is done. The spark plug is a simple device which may be compared to the percussion cap of a gun. It permits one to produce an electric spark in the cylinder when the piston is at the best point to utilize the pressure which

obtains when the compressed gas is fired. The valves are open one at a time, the inlet valve being depressed from its seat while the cylinder is filling and the exhaust valve is opened when the cylinder is being cleared. They are normally kept seated by means of compression springs. In the simple motor shown at Fig. 9, the inlet valve is operated by means of a pivoted rocker arm moved by a cam which turns at half the speed of the crank shaft. The exhaust valve operates in a similar manner, as will be explained in proper sequence.

Considering the view shown at Fig. 9, A, the first necessary operation is charging the cylinder with explosive material. The piston is at the top of its stroke and it moves toward the open end of the cylinder. The engine works as a pump and the piston draws in a charge of combustible gas through the open intake valve which is in connection with the vaporizer or device which furnishes the gas. The valve opening is assisted by a light vacuum or suction existing when the piston has traveled down a certain portion of its stroke, this supplementing the cam action as the outside air pressure is greater than that in the cylinder. The mechanical pressure produced by the cam is greater than the tension of the spring, which tends to keep the valve closed and that member is depressed from its seat and gas drawn in by the piston. At the end of the intake stroke, the start of which is shown at Fig. 9, A, and after the cylinder has filled with gas, the pressure inside and outside is the same, the cam pressure is released, and the valve spring closes the intake valve.

As the exhaust valve spring is very strong, this member has not been lifted from its seat by the difference in pressure during the suction stroke. The exhaust valve is opened by mechanical means solely and only when

operated by the cam and push-rod mechanism. The condition in the cylinder of the gas engine after the piston has reached the bottom of its stroke is very much the same that which obtains in a gun of the muzzle-loading type after the explosive charge has been introduced. We have learned that to obtain power from gunpowder that it was necessary to compact it firmly in the combustion chamber of the gun. The gasoline gas which has been taken into the engine cylinder must also be compressed before it is ignited in order to obtain power. It is compacted into one-third or one-quarter of its former volume, and whereas its pressure is about fifteen pounds per square inch before the volume is reduced, at the end of the compression stroke of the piston the pressure will be increased to forty-five, sixty, and even seventy-five pounds per square inch. At the end of this compression stroke, the start of which is shown at B, Fig. 9, the conditions in the engine cylinder are the same as those which prevail in the barrel of the gun after the powder has been tightly rammed in the closed end of the gun barrel and the wadding and ball forced in on top of it. The explosion of the gas by the electric spark is shown at C, while the beginning of the exhaust stroke is depicted at D.

With a one-cylinder, four-cycle engine it will be apparent that we have one useful power stroke in every four strokes of the piston. These four reciprocating movements are transformed into two complete rotary movements of the crank shaft to which the connecting rod is fastened. If we have a two-cylinder engine we can obtain one explosion for each revolution of the fly wheel or crank shaft and a more even turning effort and steadier power application will result. By using four cylinders it is possible to have one delivering power right after

its neighbor leaves off and so a reasonably constant turning moment or more steady power delivery is possible than can be obtained with either a one- or two-cylinder engine. In the Ford four-cylinder engine one obtains two explosions for each revolution of the flywheel. The position of the various pistons and their relation to each other when the front cylinder is about to fire is clearly

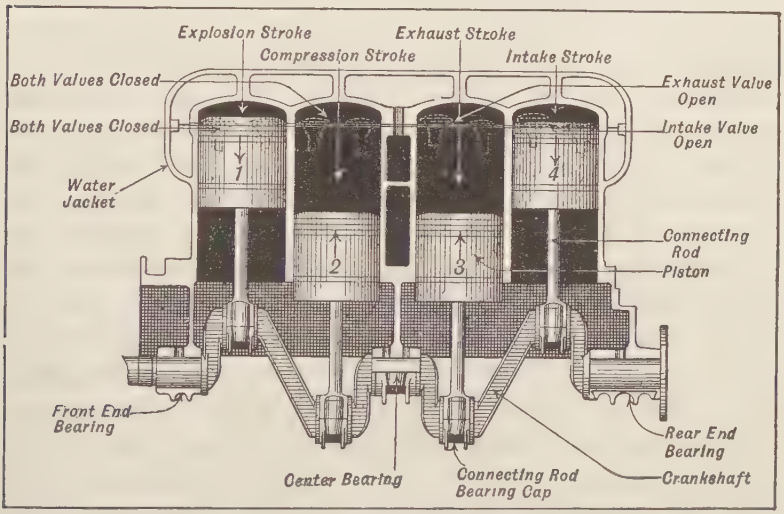

Fig. 10.—Diagram Showing the Relation of the Pistons and Crank Shaft Throws of the Ford Four Cylinder Motor when Piston No. 1 is about to Receive the Force of Gas Exploded in the Combustion Chamber.

shown at Fig. 10. Pistons Nos. 1 and 4 are at the top of the stroke as the crank pins operating them are on the same plane. Pistons Nos. 2 and 3 are at the bottom of the stroke as their crank pins are on the same line. It will be evident that the crank shaft of a four-cylinder engine must have four crank throws, one for each piston member.

In the Ford engine the firing order is 1, 2, 4, 3, which means that the front cylinder fires first, then the second cylinder, then the fourth cylinder, and lastly the third cylinder. The four operations of the cycle—suction, compression, explosion and exhaust—are repeated in regular order in each of the four cylinders according to the firing order. The pistons move downward during the explosion and intake strokes and they move upward during the compression and exhaust strokes. As can be readily ascertained from Fig. 10, when piston No. 1 is at the top of its stroke with the gas above it in the combustion chamber fully compressed and ready for ignition, piston No. 2 is at the bottom of the suction stroke and just at the beginning of its compression stroke. Both valves in cylinders Nos. 1 and 2 are closed. When the piston in cylinder No. 3 starts moving up, it will force the burnt gas out of cylinder No. 3, through the open exhaust valve. Piston No. 3 is starting on its exhaust stroke while piston No. 2 is moving in the same direction, only performing its compression stroke. Piston No. 4 is moving in the same direction as piston No. 1, which is about to be forced down by the pressure of the exploded gas, and as the inlet valve is opened in cylinder No. 4 a charge of gas will be drawn in from the carburetor when the piston moves down.

We have different conditions in the various cylinders, as follows: During the first half of the first revolution of the motor crank shaft, piston No. 1 is on its explosion stroke, No. 2 is compressing the gas, piston No. 3 is pushing out burned gas, while piston No. 4 is drawing in a fresh charge. During the second half of the first revolution of the crank shaft, during which the pistons reverse from the position shown in Fig. 10, piston No. 1 is about

to clear the cylinder of burnt gas, piston No. 2 is to receive the force of the explosion, piston No. 3 is to draw in a fresh charge, while piston No. 4 is about to compress the gas taken in on the preceding down stroke. At the beginning of the first half of the second revolution of the crank shaft the pistons are again in the positions shown at Fig. 10, though the functions they are performing are not the same. Piston No. 1 is about to draw in a fresh charge of gas. Piston No. 2 is about to force out exhaust gas. Piston No. 3 is about to compress a charge, while piston No. 4 is in position to be acted on by the explosion that is to take place in cylinder No. 4 as soon as the gas is ignited. During the second half of the second revolution, piston No. 1 is compressing a charge, piston No. 2 is sucking in gas, piston No. 3 is being acted on by an explosion, while cylinder No. 4, in which a charge has exploded on the previous stroke of the piston, is being cleared of burnt gas. It will be apparent that by using four cylinders, as in the Ford motor, practically steady power application is obtained.

Engine Parts and Their Functions.—A part sectional view of the Ford power plant is presented at Fig. 11, with practically all motor parts clearly outlined. The functions of the principal elements have been previously described, but in addition to these there are a number of minor parts which are equally necessary to secure efficient engine action. For example, each piston is provided with three packing rings fitting into grooves machined around each piston, two being above the piston pin and one below that member. The purpose of these packing rings is to prevent escape of the gas past the pistons on the compression or explosion strokes. It would not be possible to secure a practically gas tight joint

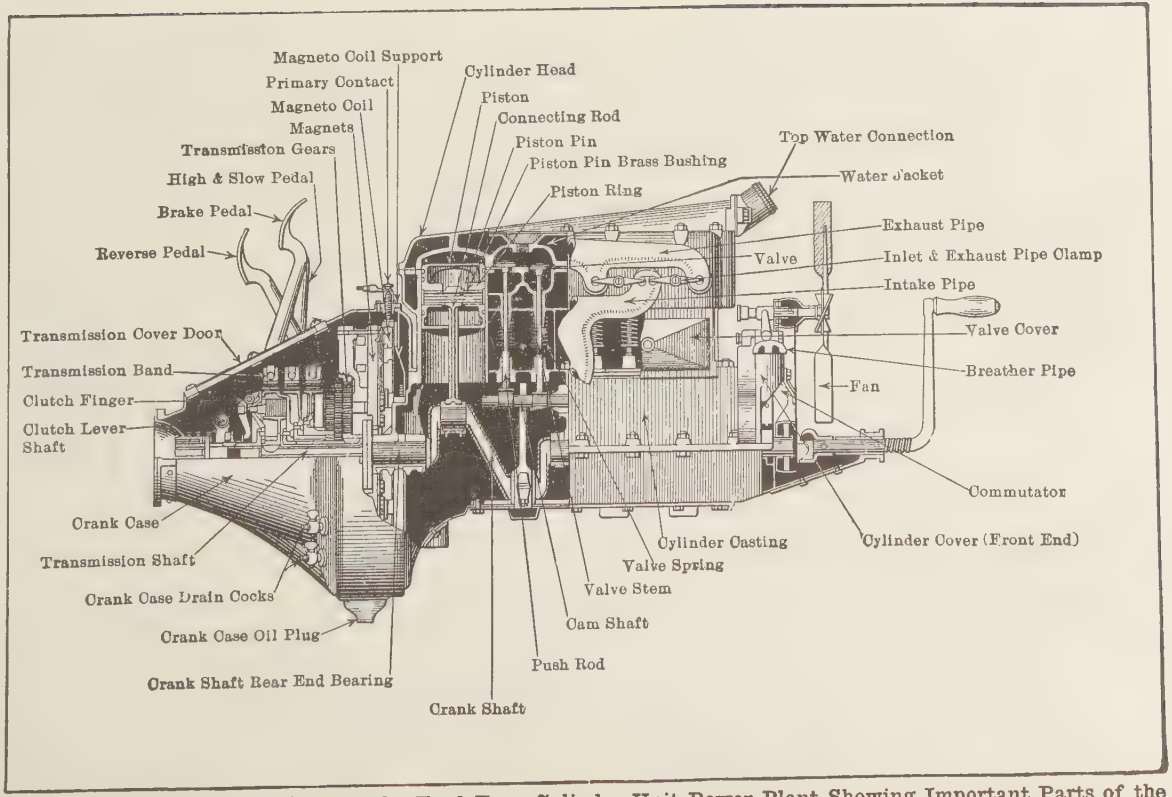

Fig. 11.—Part Sectional View of the Ford Four Cylinder Unit Power Plant Showing Important Parts of the Power Generating and Transmission System.

without these rings because the piston could not be fitted so tightly to the cylinder that it would retain the gas. There would be considerable friction between the piston and cylinder walls, and in addition much power would be consumed because of this retarding influence which would increase as the piston became heated and expanded. By using packing rings, it is possible to make the piston enough smaller than the cylinder bore so that even when heated and expanded to its limit it will not seize or bind in the cylinder as long as lubrication is properly maintained. The piston rings are sufficiently elastic owing to a slotted opening in each ring to allow springing them over the piston when it is necessary to remove them for cleaning or examination. Another function of the piston ring is to take the wear caused to the rapid sliding movement of the piston. It is easier to renew relatively cheap piston rings instead of supplying new piston castings to compensate for wear after the engine has been in use for a time.

The connecting rods are attached to the pistons by the medium of a piston pin which is clamped in an eye at the upper end of the connecting rod and which oscillates in bronze bushings forced into the piston bosses. The connecting rod is a vanadium steel drop forging provided with a capped babbit bearing at its lower end, where it encircles the crank pin of the crank shaft. The cylinder unit consists of two members, an iron cylinder block which is cast integral with the upper half of the crank case and the cast iron cylinder head which is a removable member that can be taken off to provide easy access to the interior of the combustion chamber when carbon deposits must be cleaned out or the valves ground. The retaining bolts holding the cylinder head in place are clearly shown

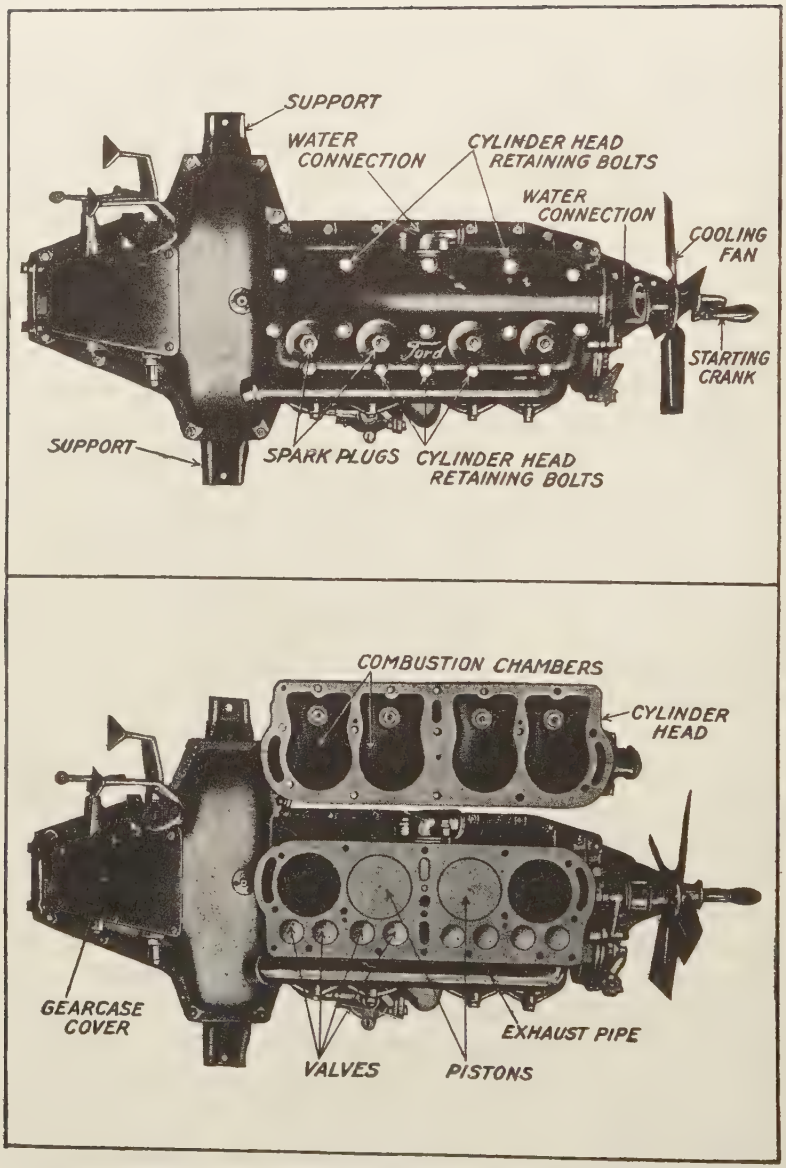

Fig. 12.—Depicting the Distinctive Design of the Ford Motor which Employs a Removable Cylinder Head to Permit Ready Access to the Combustion Chambers, Valves and Piston Parts.

at the top of Fig. 12, while the appearance of the inside of the cylinder block when the cylinder head is removed is outlined in the lower portion of the illustration. Two valves are provided for each cylinder, these being side by side, all on the same side of the cylinder. The one that admits the fresh charge from the carburetor is called the "intake," whereas the one through which the exploded gas is driven out and which opens the passage between the combustion chamber and the exhaust manifold is called the "exhaust" valve.

The sectional view of the cylinder at Fig. 13, C, shows very clearly the manner in which the valve is installed, no valve seating spring being shown in order to simplify the illustration. Both inlet and exhaust valves are kept seated by means of coil springs which bear against a cap carried at the lower end of the valve stem. The appearance of the valve and its operating plunger is clearly shown at A, Fig. 13. The valves are opened at the proper time by the action of a simple member called a cam. This is of the form shown at Fig. 13, B, and consists of an approximately circular member except for a raised portion at one point on its periphery. One cam is provided for each valve, there being eight cams in the Ford engine all formed integrally with the cam shaft. As will be apparent by referring to B, Fig. 13, the valve plunger is raised when the pointed portion of the cam passes under it.

The cam shaft is revolved at half the crank shaft speed, and is driven by means of a large gear which meshes with a pinion half its size called the small time gear keyed to the crank shaft. An important point to observe is that the valves are properly timed. This may be easily determined by checking to see if the factory timing has

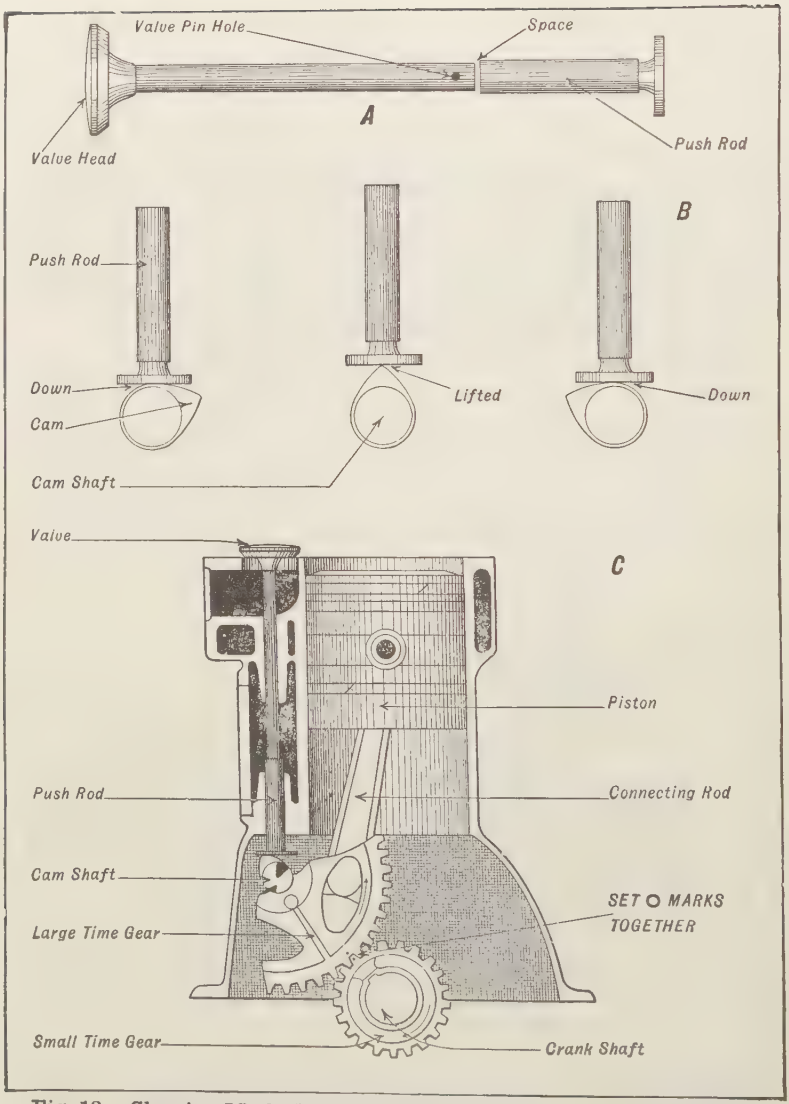

Fig. 13.—Showing Method of Ford Valve Construction and Operation.

been disturbed. The timing is easily accomplished by having the tooth on the small time gear marked with a 0 fit between two teeth on the large timing gear at a corresponding 0 point. At this time the first cam on the cam shaft should point in a direction opposite from the zero marks, as shown at Fig. 13, C. The points of opening and closing of the valves and the troubles that are apt to materialize in these members will be discussed fully in the chapter on Engine Maintenance.

The crank shaft is one of the most important members of the engine, because it receives all the power delivered to it by the pistons and conveys the energy to the transmission gearing from which the drive is taken to the rear wheels of the car. The crank shaft, which is a vanadium steel forging, is supported by three main bearings, one at each end and one at the center. The flywheel member attached to the crank shaft serves to equalize the power application and steady the action of the engine as it serves to keep the crank shaft moving the brief intervals of time between the ending of one explosion and the beginning of the next one. The manifolds are pipes used to convey the gas in or out of the cylinder. The intake pipe is an aluminum or cast iron member that conveys the fresh gas from the carburetor to the inlet valve chambers. The exhaust pipe directs the burnt gas to the muffler. The four-blade, belt-driven fan at the front end of the motor forms part of the engine-cooling system. The starting crank is provided so the engine can be set in motion by hand to move the pistons until an explosion is obtained when it is desired to start it. The various parts of the transmission gear and control assembly will be described in the next chapter. Access to the interior of the crank case is obtained by removing a pressed steel

plate on the bottom of the engine. The valve springs may be reached by removing steel plates covering the chambers in which they are housed. The inlet and exhaust pipes are held in place by simple clamp or stirrup members while the cylinder head is secured to the cylinder casting by substantial removable retaining bolts. The lower part of the engine crank case, which is a steel stamping, is fastened to the upper portion by another series of removable machine bolts. If the illustration at Fig. 11 is studied carefully no difficulty should be experienced in identifying the various parts of the Ford engine and understanding the work they do.

The Ford Carburetion System.—There is no appliance that has more material value upon the efficiency of the internal combustion motor than the carburetor or vaporizer which supplies the explosive gas to the cylinders. It is only in recent years that engineers have realized the importance of using carburetors that are efficient and that are so strongly made that there will be little liability of derangement. As the power obtained from the gas engine depends upon the combustion of fuel in the cylinders, it is evident that if the gas supplied does not have the proper proportions of elements to insure rapid combustion the efficiency of the engine will be low. When a gas engine is used as a stationary installation it is possible to use ordinary illuminating or natural gas for fuel, but when this prime mover is applied to automobile or marine service it is evident that considerable difficulty would be experienced in carrying enough compressed coal gas to supply the engine for even a very short trip. Fortunately, the development of the internal combustion motor was not delayed by the lack of suitable fuel. Engineers were familiar with properties of certain liquids which gave

off vapors that could be mixed with air to form an explosive gas which burned very well in the engine cylinders. A very small quantity of such liquids would suffice for very satisfactory periods of engine operation. The problem to be solved before these liquids could be applied in a practical manner was to evolve suitable apparatus for vaporizing them without waste. Among the liquids that can be combined with air and burned, gasoline is the most common and is the fuel utilized by the majority of internal combustion engines employed in self-propelled conveyances.

Principles of Carburetion Outlined.—The process of carburetion is combining the volatile vapors which evaporate from the hydrocarbon liquids with certain proportions of air to form an inflammable gas. The quantities of air needed vary with different liquids and some mixtures burn quicker than do other combinations of air and vapor. Combustion is simply burning and as we have seen, it may be rapid, moderate, or slow. Mixtures of gasoline and air burn quickly, in fact the combustion is so rapid that it is instantaneous and we obtain what is commonly termed an "explosion." Therefore the explosion of gas in the automobile engine cylinder which produces the power is due to a combination of chemical elements which produce heat. If the gasoline mixture is not properly proportioned the rate of burning will vary, and if the mixture is either too rich or too weak the energy of the explosion is reduced and the amount of power applied to the piston is decreased proportionately.

In determining the proper proportions of gasoline and air, one must take the chemical composition of gasoline into account. The ordinary liquid used for fuel is said to contain about eighty-four per cent. carbon and sixteen per

cent. hydrogen. Air is composed of oxygen and nitrogen and the former has a great affinity or combining power with the two constituents of hydrocarbon liquids. Therefore, what we call an explosion is merely an indication that oxygen in the air has combined with the carbon and hydrogen of the gasoline.

In figuring the proper volume of air to mix with a given quantity of fuel one takes into account the fact that one pound of hydrogen requires eight pounds of oxygen to burn it, and one pound of carbon needs two and one third pounds of oxygen to insure its combustion. Air is composed of one part of oxygen to three and one half portions of nitrogen by weight. Therefore, for each pound of oxygen one needs to burn hydrogen or carbon four and one half pounds of air must be allowed. To insure combustion of one pound of gasoline which is composed of hydrogen and carbon we must furnish about ten pounds of air to burn the carbon and about six pounds of air to insure combustion of hydrogen, the other component of gasoline. This means that to burn one pound of gasoline one must provide about sixteen pounds of air.

While one does not usually consider air as having much weight, at a temperature of sixty-two degrees Fahrenheit about fourteen cubic feet of air will weigh a pound, and to burn a pound of gasoline one would require about two hundred cubic feet of air. This amount will provide for combustion theoretically, but it is common practice to allow twice this amount because the element nitrogen, which is the main constituent of air, is an inert gas which instead of aiding combustion, acts as a deterrent of burning. In order to be explosive, gasoline vapor must be combined with certain quantities of air. Mixtures that are rich in gasoline ignite quicker than those which have

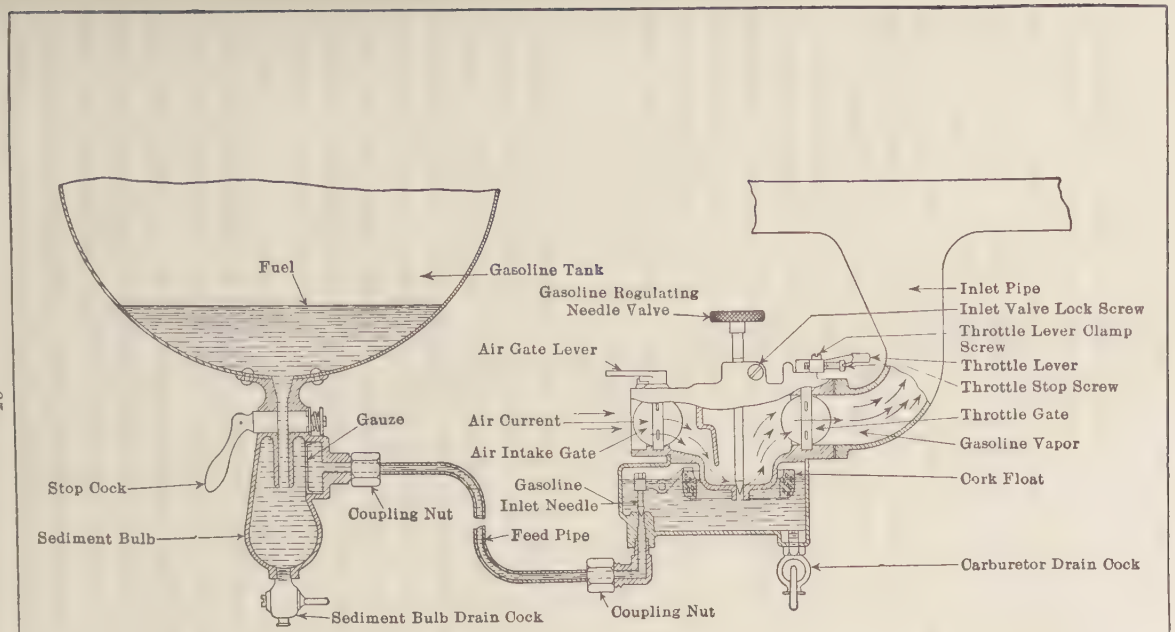

Fig. 14.—The Ford Model T Fuel Supply and Gas Making System.

more air, but these are only suitable when starting or when running slowly. The endeavor is to obtain a correct mixture of gasoline and air as it not only burns quicker but produces the most heat and the most effective pressure in pounds per square inch of piston top area.

The amount of compression of the charge before ignition also has material bearing on the force or power of the explosion. The higher the degree of compression the greater the force exerted and the more rapid the combustion of the gas. Mixtures varying from one part of gasoline vapor to four of air to others having one part of gasoline vapor to thirteen of air can be ignited, but the best results are obtained when the proportions are one to five or one to seven, as this mixture is the one that will produce the highest temperature the quickest explosion and the most pressure.

The Ford fuel system is clearly shown in accompanying diagram, Fig. 14. The gasoline supply is carried in a cylindrical galvanized iron tank under the front seat. This is joined to the carburetor by a simple pipe line of flexible soft copper tubing. The construction of one type of carburetor is shown in this illustration. Before the gasoline can flow to the vaporizer it must pass through the sediment bulb and filtering device on the bottom of the tank.

Utility of Gasoline Strainer.—Some carburetors include a filtering screen at the point where the liquid enters the float chamber in order to keep dirt or any other matter which may be present in the fuel from entering the float chamber. This is not general practice, however, and the majority of vaporizers do not include a filter in their construction. It is very desirable that the dirt should be kept out of the carburetor because it may get under the float

controlled fuel inlet valve and cause flooding by keeping it raised from its seat. If dirt finds its way into the spraying orifice it may block the opening so that no gasoline will issue or may so constrict the passage that only very small quantities of fuel will be supplied the mixture. Where the carburetor itself is not provided with a filtering screen a simple filter is usually installed in the pipe line between the gasoline tank and the float chamber.

The simple form of filter and separator shown at Fig. 14 is used in the Ford fuel system. That illustrated consists of a simple hollow brass casting having a readily detachable gauze screen facing the outlet and a settling chamber of sufficient capacity to allow the foreign matter to settle to the bottom from which it may be drained out by a pet cock. Any water or dirt in the gasoline will settle to the bottom of the chamber, and as all fuel delivered to the carburetor must pass through the wire gauze screen it is not likely to contain impurities when it reaches the carburetor. The heavier particles, such as scale from the tank or dirt and even water, all of which have greater weight than the gasoline, will sink to the bottom of the chamber whereas light particles, such as lint, will be prevented from flowing into the carburetor by the filtering screen.

What a Carburetor Should Do.—While it is apparent that the chief function of a carbureting device is to mix hydrocarbon vapors with air to secure mixtures that will burn, there are a number of factors which must be considered before describing the principles of vaporizing devices. Almost any device which permits a current of air to pass over or through a volatile liquid will produce a gas which will explode when compressed and ignited in the motor cylinder. Modern carburetors are not only called upon to

supply certain quantities of gas, but these must deliver a mixture to the cylinders that is accurately proportioned and which will be of proper composition at all engine speeds.

Flexible control of the engine is sought by altering the engine speed through regulation of the supply of gas to the cylinders. The power plant should run from its lowest to its highest speed without any irregularity in torque, i.e., the acceleration should be gradual rather than spasmodic. As the degree of compression will vary in value with the amount of throttle opening the conditions necessary to obtain maximum power differ with varying engine speeds. When the throttle is barely opened the engine speed is low and the gas must be richer in fuel than when the throttle is wide open and the engine speed high. When an engine is turning over slowly on low throttle the compression has low value and the conditions are not so favorable to rapid combustion as when the compression is high. At high-engine speeds the gas velocity through the intake piping is higher than at low speeds, and regular engine action is not so apt to be disturbed by condensation of liquid fuel in the manifold due to excessively rich mixture or a superabundance of liquid in the stream of carbureted air.

The Ford Float Feed Carburetor.—The modern form of spraying carburetor is provided with two chambers, one a mixing chamber through which the air stream passes and mixes with a gasoline spray, the other a float chamber in which a constant level of fuel is maintained by a simple mechanism. A nozzle or its equivalent is used in the mixing chamber to spray the fuel through and the object of the float is to maintain the fuel level to such a point that it will not overflow when the motor is not drawing in a

charge of gas. Two different forms of carburetors have been used on Ford cars as regular equipment. One of these is shown in connection with the Fuel system at Fig. 14, the other is outlined at Fig. 15. The principle of

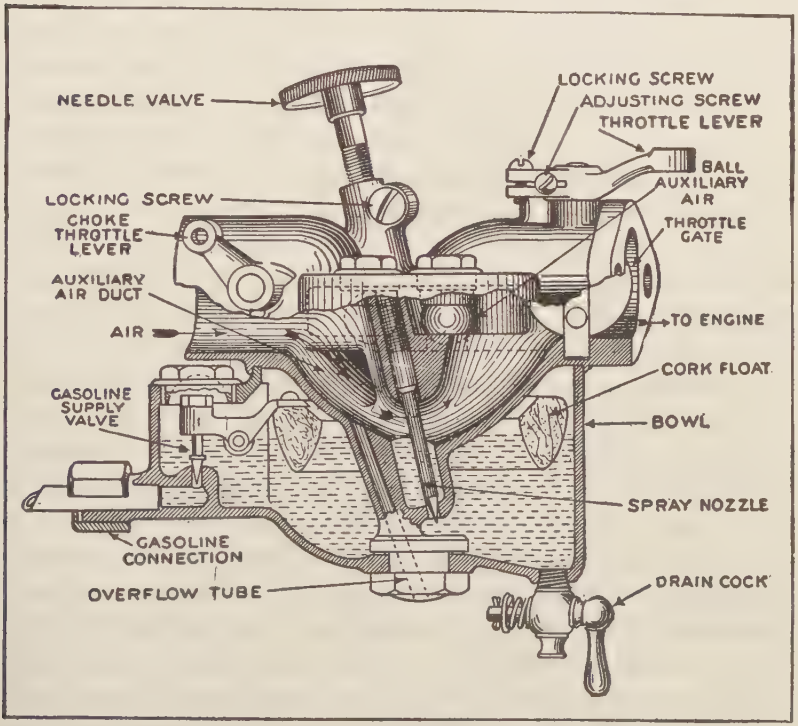

Fig. 15.—Part Sectional View of Special Kingston Carburetor Used on some Ford Model T Cars.

action is the same for both types, except that one has an auxiliary air attachment consisting of a series of bronze balls which open progressively as the engine suction increases to admit more air into the mixture. This form is shown at Fig. 15. The Ford carburetor has but one adjustment and that by the gasoline needle valve. The

fuel enters the float bowl through a connection at its side, its level in that member being regulated by the height of a cork float. The float raises as the supply increases to a point where the gasoline supply regulating valve is seated, this cutting off the flow of gasoline. As the gasoline is used up and the amount in the bowl becomes less the float lowers and through the medium of a bell crank or simple lever lifts the needle from its seat and permits more gasoline to flow into the float bowl from the gasoline tank. It is evident that a constant level of gasoline in the float bowl is maintained by the automatic action of the float controlled needle. The amount of gasoline entering into the mixture is governed by the needle valve controlling the orifice through which the fuel flows from the float bowl to the interior of the mixing chamber. The volume of gaseous mixture entering the intake pipe, which in turn determines power and speed of the motor, is controlled by opening or closing a simple gate or shutter valve, similar to the damper used in a stove pipe, according to the engine speed desired by the driver.

A mixture that contains too much air and not enough gasoline is known as "lean" mixture. If there is too much liquid fuel and not enough air the gas is called a "rich" mixture. Neither one of these conditions is desirable as the engine will be hard to start and lack power on a lean mixture and it will tend to overheat and be wasteful of fuel as well as promoting carbon deposits if the mixture is too rich. A rich mixture is indicated by a heavy black exhaust smoke having a disagreeable smell. When this condition is manifested the needle valve regulator on the dash should be screwed down or to the right until the engine begins to misfire, then the gasoline feed is gradually increased by opening the needle valve in the

other direction slowly to that point where the motor runs steadily and at a high rate of speed with a full throttle opening, at the same time, there being no evidence of smoke in the exhaust. The reader should be cautioned that a white smoke coming out of the exhaust indicates too much lubricating oil and not too much gasoline. If popping sounds are heard in the carburetor when the engine is running it is because the mixture is too lean and the gasoline needle valve should be opened just enough to permit the engine to run well and yet not back fire.

As will be evident by studying the sectional views of Figs. 14 and 15 the gasoline level in the carburetor is at just such a height that a small pool of gasoline will collect at the bottom of the mixing chamber. The entering air current passing the air intake shutter is deflected toward the bottom of the float chamber by a suitable baffle plate or other obstruction and must sweep across the surface of the gasoline and become thoroughly impregnated with particles of liquid fuel before it can pass into the intake manifold. The action at high speed is different from that present at low speed because the greater engine suction and more rapidly moving air column does not give the gasoline a chance to accumulate in a pool at the bottom of the mixing chamber, but draws it from the orifice regulated by the needle valve in the form of a spray. The construction of a Ford carburetor is such that a correct gas is provided for easy starting while a leaner mixture is obtained as the engine speed increases and conditions become such that it can be utilized to advantage.

The Ford Ignition System.—The essential elements of any electrical ignition system, either high or low tension are: First, a simple and practical method of current production; second, suitable timing apparatus to cause the

spark to occur at the right point in the cycle of engine action; third, suitable wiring and other apparatus to convey the current produced by the generator to the sparking member in the cylinder. The ignition system used on

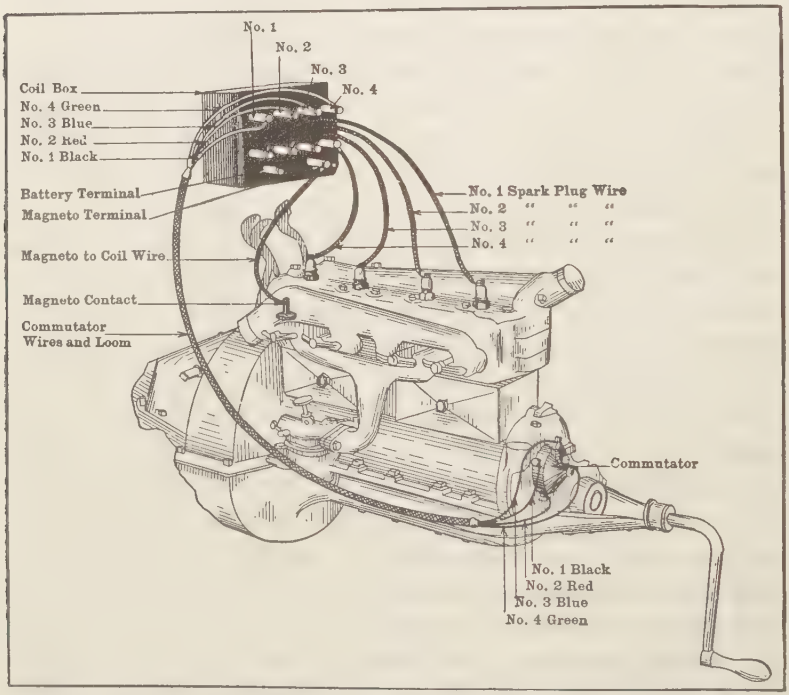

Fig. 16.—View of Ford Power Plant Showing Main Parts of the Ford Ignition System. Note Location of Timer and Induction Coil Box.

the Ford is a very simple and practical one. A four contact primary timer is mounted at the front end of the cam shaft, one contact being provided for each cylinder. Wires run from this device to the coil units on the dash as shown in diagrams, Figs. 16 and 18. Other wires run from the induction coil units to the spark plugs, these are called

secondary wires, while those going to the timer are called primary wires. When the car is shipped from the factory, no batteries are furnished, so only the magneto terminal is joined to the coil. This leaves one terminal free to be connected to a battery of dry cells when that is furnished by the owner. The magneto furnishes all the current that is needed to run the car and the engine may be easily started on the magneto when the coil vibrators are properly adjusted as this device supplies a strong current at ordinary cranking speeds.

Induction Coil System Explained.—In order to enable the reader to understand the basic principles of ignition apparatus the important parts of a simple battery ignition system for a one-cylinder engine are shown at Fig. 17. The current is supplied from two sources. One of these is a storage battery, the other a dry cell battery. A mechanical generator could be substituted for one of the batteries, if desired. The induction coil or transformer coil is utilized to intensify the low tension current produced by the battery to one of greater value having sufficient voltage to jump the air gap between the points of the spark plug. The induction coil unit consists of a double wound coil surrounding a soft iron core piece. The primary coil or the one through which the battery current flows consists of two or three layers of comparatively coarse wire wound around the central core. The secondary coil is composed of a large number of turns of fine threadlike wire. Every time a current of electricity is permitted to flow through the primary coil it energizes the soft iron core, turns it into a magnet and the result is the production of a current in a secondary coil by magnetic induction, which has many times the voltage or pressure of the primary battery current pro-

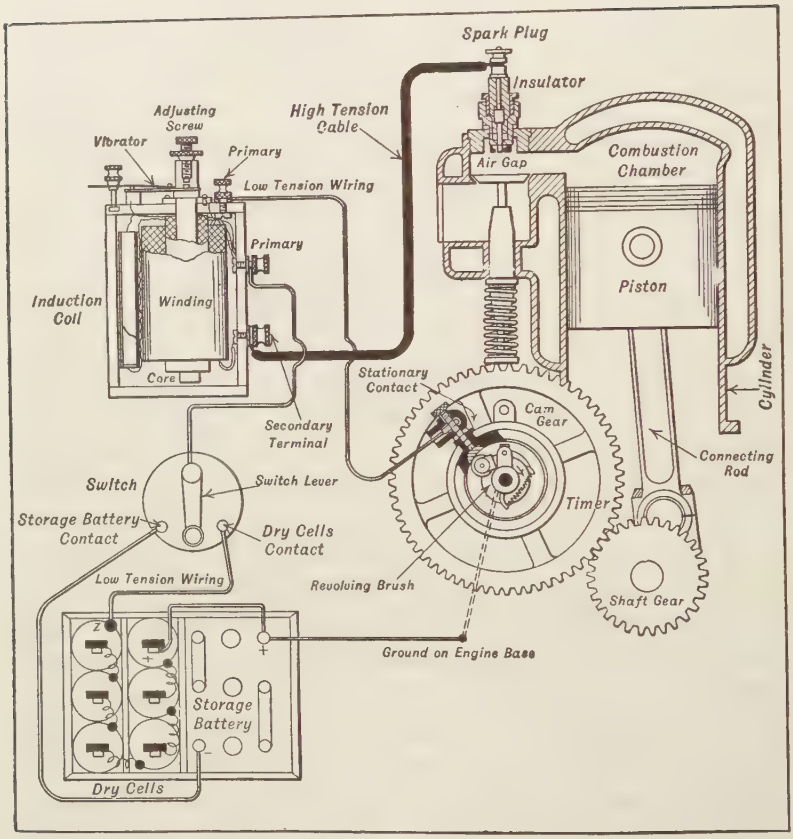

Fig. 17.—Diagram of Simple High Tension Ignition System for One Cylinder Motor to show Arrangement and Wiring of the Principal Parts.

ducing it, though its amperage is greatly reduced. The average secondary coil used for ignition purposes will deliver a current of eight to ten thousand volts pressure. The amperage or quantity flowing is so slight that this voltage may pass through the human body without producing any injury.

Each time that a spark is desired between the points of the spark plug which projects into the interior of the combustion chamber, a contact is established between the revolving brush and the stationary contact of the timer. This permits the current to flow from either the dry or storage battery depending upon the position of the controlling switch lever, this current passing through the primary winding of the transformer coil. There is no electrical connection between the primary and secondary windings. The secondary winding is grounded at one end and is joined to the spark plug by a high tension cable at the other. In a simple one-cylinder engine of the four-cycle type but one explosion is possible in every two revolutions of the flywheel or in each four strokes of the piston. If the cam shaft which carries the revolving brush of the timer rotates at half the engine speed it will be apparent that but one electrical contact will be established for two revolutions of the crank shaft. This contact can be timed to take place only when the piston reaches the end of its compression stroke, at which time it is necessary to explode the gas to produce power.

A vibrator member, which is a simple automatic make-and-break arrangement operated by the magnetism of the induction coil core piece insures that the current will be sent through the primary winding in a series of waves during the main contact intervals. With a vibrator coil a stream of small sparks jump the air gap of the spark plug all the time that the revolving brush roller is in contact with the stationary contact segment of the timer. With a four cylinder engine it will be apparent that four contacts must be established for each two revolutions of the crank shaft and that the timer should have four stationary contact members which can be served by a com-

mon revolving brush. In the Ford ignition system four independent vibrator coils are provided, one for each cylinder. The method of wiring is clearly shown in Fig. 16, which gives the actual appearance of the parts of the ignition system while the course of the current may be readily followed by studying the diagram, Fig. 18. In this diagram the coil units are shown removed from the

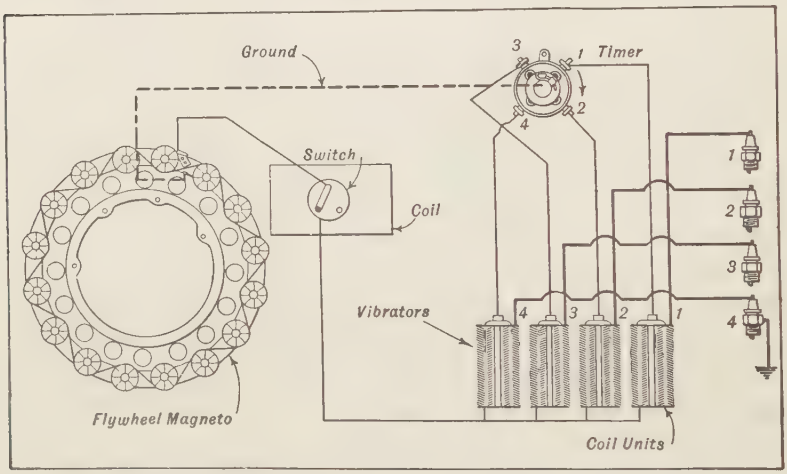

Fig. 18.—Wiring Diagram Showing Method of Connecting Parts of the Ford Ignition System.

coil box in order to depict clearly the way the various connections are made. It will be evident that as soon as the revolving brush of the timer leaves the metal segment and all the time that it is in contact with the fibre ring in which the contact segments are imbedded that no current can flow through any of the induction coil units. As soon as the brush establishes contact with one of the segments the current is delivered to the unit that serves the cylinder that is about to fire, the wires being con-

nected in such a way that coil unit supplying spark plug No. 1 works first, then No. 2, followed by No. 4 and lastly No. 3. This sequence of explosions is followed all the time the engine is in operation.

The Ford Timer.—Anyone familiar with the basic principles of internal combustion engine action will recognize the need of incorporating some device in the ignition system, which will insure that the igniting spark will occur only in the cylinder that is ready to be fired and at the right time in the cycle of operations. There is a certain definite point at which the spark must take place, this having been determined to be at the end of the compression stroke, at which time the gas has been properly compacted and the piston is about to start returning to the bottom of the cylinder again. Timers or distributors are a form of mechanically operated switch designed so that hundreds of positive contacts which are necessary to close and open the circuit may be made per minute without failure. When a timer is to be used in connection with a four-cylinder engine the compact form shown at Fig. 19 is usually adopted. This has many desirable features and permits of timing the spark with great accuracy. The contact segments are spaced on quarters and are imbedded in a ring of fibre which is retained in a casing of aluminum. The central revolving element carries a lever which has a roll at one end and a tension spring designed to keep the roller in contact with the inner periphery of the fibre ring at the other. The segments are of steel and are accurately machined and hardened, and as the surface of the roller is also hardened, this form of timer is widely used because it provides a positive contact and works smoothly at all engine speeds, as well as having great endurance. Every time the roller makes con-

tact with one of the segments, if the coil switch is on either battery or magneto, a current will flow from the generator through the timer and to the coil units to which the segment is wired. This produces a flow of current through the secondary wire to the spark plug where a spark jumps

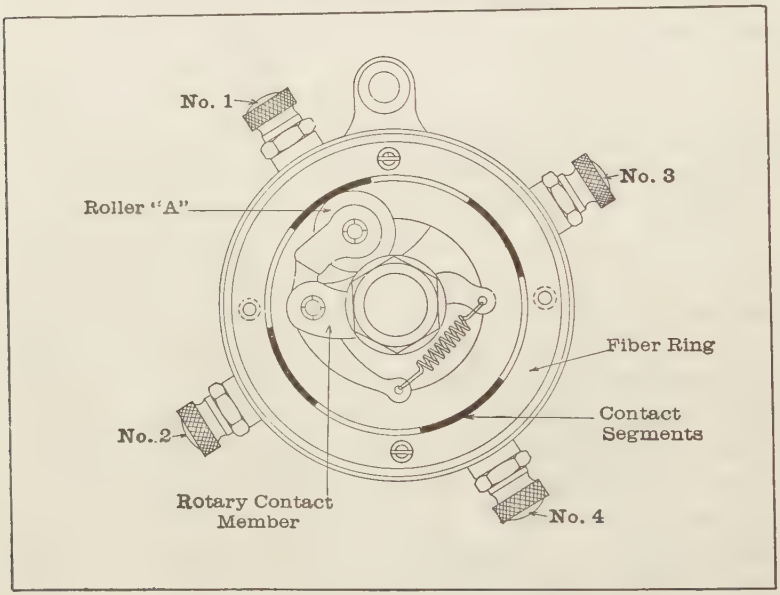

Fig. 19.—Parts of the Ford Ignition Timer.

the air gap between the electrodes and explodes the compressed gas surrounding the plug points.

Why a Magneto is Used On The Ford.—The fact that any chemical battery cannot maintain a constant supply of electricity has militated against their use to a certain extent and the modern motorist demands some appliance that will deliver an unfailing supply of electricity. The strength of batteries is reduced according to the amount of service they give. The more they are used the weaker

they become. The modern multiple cylinder engines are especially severe in their demands upon the current producer and the rapid sequence of explosions in the Ford high speed four cylinder motor produces practically a

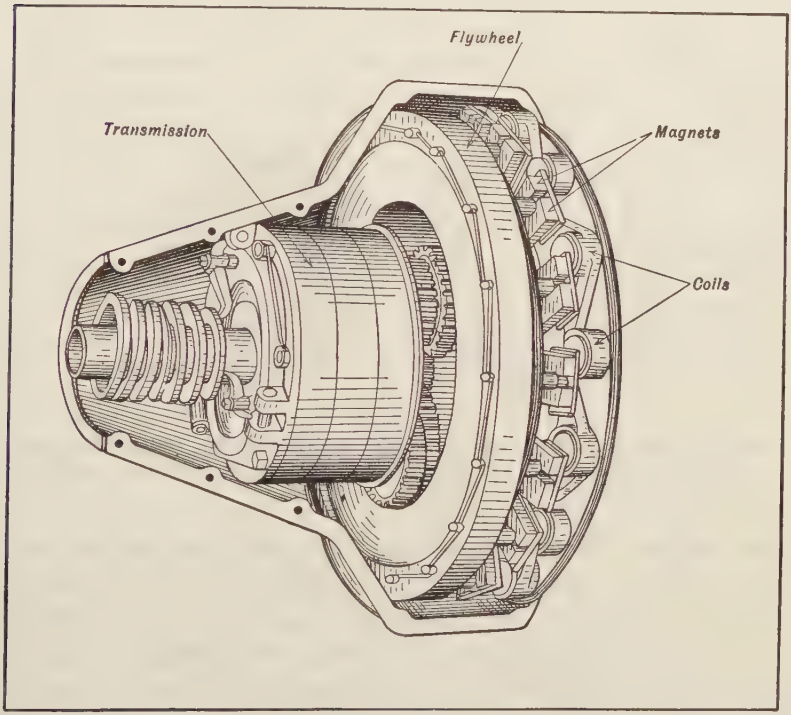

Fig. 20.—Showing Coils and Magnet that Comprise the Ford Magneto and their Relation to the Flywheel and Transmission Gear.

steady drain upon the battery. When dry cells are used their discharge rate is very low and as they are designed only for intermittent work, when the conditions are such that a constant flow of current is required they are unsuitable and will soon deteriorate.

A very ingenious and practical application of the dynamo is shown at Fig. 20, this being used on the Ford car only. The electric generator is built in such a manner that it forms an integral part of the power plant. The magneto field is produced by a series of revolving permanent magnets which are joined to and turn with the flywheel of the motor. The sixteen current producing coils

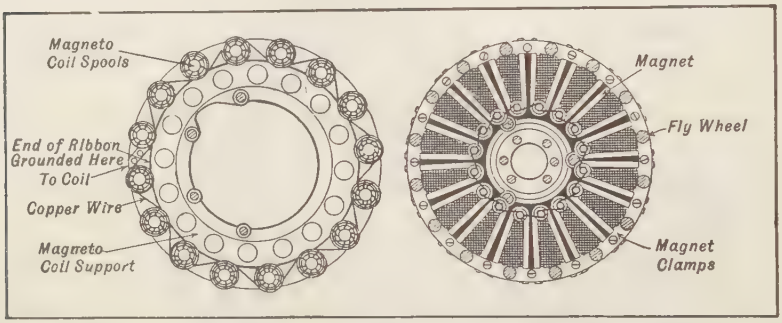

Fig. 21.—Views Showing Construction of Stationary Magneto Coil Carrying Member at Left and Rotary Magnet Carrier that Also Acts as the Motor Flywheel at Right.

are carried by a fixed plate which is attached to the engine base. (See Fig. 21.) This apparatus is really a magneto having a revolving field and a fixed armature, and as the magnets are driven from the flywheel there is no driving connection to get out of order and cause trouble. The coils in which the current is generated are stationary, no rotating commutators or fixed contact brushes are needed to collect the current because the electricity may be easily taken from the fixed coils by a simple direct connection. It has been advanced that this form of magneto is not as efficient as the conventional patterns because more metal and wire is needed to produce the current required. As the magnets which form the heaviest

portion of the apparatus are joined to the flywheel, which can be correspondingly lighter, this disadvantage is not one that can be considered seriously because the magnet weight is added to that of the motor flywheel, the combined mass of the two being equal to that of an ordinary balance member used on any other engine of equal power. The current supply will continue as long as the engine runs and a practically unfailing source of electricity is assured all Ford owners.

Many owners provide a set of dry cells as an auxiliary source of current, as these are of value in starting the motor sometimes under conditions where the engine cannot be cranked briskly enough to get a strong magneto spark. Dry cells are useful as a check upon the magneto and are also of value when adjusting the coil vibrators. The engine will also start on the spark sometimes without cranking when dry cells are used. The writer operated his car for two seasons with the magneto alone and without a battery and never felt the need of one. It was only when a storage battery was added to the equipment to operate electric side and tail lamps that the battery terminal of the coil was put into circuit, though it was seldom used.

Wiring Dry Cells.—One of the disadvantages of primary cells, as those types, which utilize zinc as a negative element are called, is that the chemical action produces deterioration and waste of material by oxidization. Dry cells are usually proportioned so the electrolyte and depolarizing materials become weaker as the zinc is used and when a dry cell is exhausted it is not profitable to attempt to recharge it because new ones can be obtained at a lower cost than the expense of renewing the worn elements would be. On four-cylinder cars dry cells should

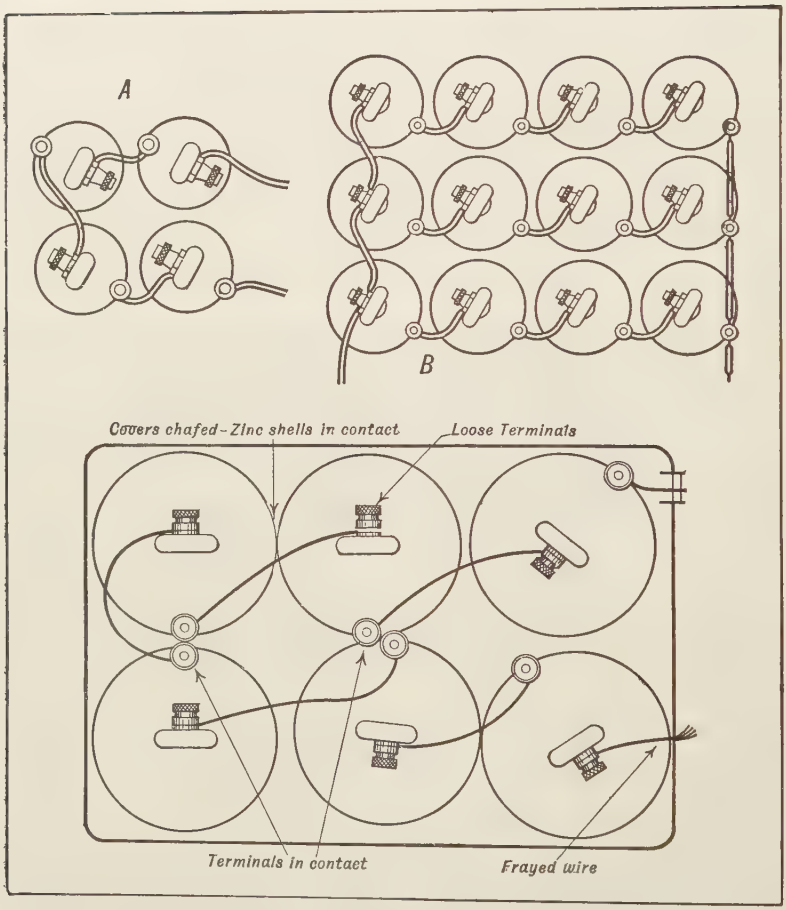

Fig. 22.—Illustrating Method of Connecting Dry Cells in Series at A and in Series Multiple at B. The Lower Illustration Shows Some of the Points to be Watched For When Dry Cells Are Installed in Metal Battery Boxes.

be joined in multiple series, which is more enduring than if the same number were used independently in single-series connection. A disadvantage of a dry cell battery

is that it is suited only for intermittent service and it will soon become exhausted if used where the current demands are severe. For this reason, most automobiles in which batteries only are used for ignition, employ storage or secondary batteries to furnish the current regularly used and set of dry cells is provided for use only in cases of emergency when the storage battery becomes exhausted. To join dry cells in series, the zinc of one cell should be joined with the carbon of the adjacent member by a flexible conductor. This will leave the carbon of one end cell and the zinc of other end cell free so they can be joined to the apparatus in the outer circuit (see Fig. 22, A).

When it is desired to obtain more amperage or current quantity than could be obtained from a single cell they are joined in series-multiple connection, as at Fig. 22, B. With this method of wiring two or more sets of four cells which have been joined in series are used. The zinc of one set is joined with the zinc element of the others and the carbon terminals are similarly connected. Any number of sets of cells may be connected in series-multiple, and the amperage of the combination is increased proportionately to the number of sets joined together in this manner. When dry cells are connected in series the voltage of one cell is multiplied by the number of cells and the amperage obtained from the set is equal to that of one cell. When connected in series-multiple, as shown at Fig. 22, B, the amperage is equal to three cells, and the voltage produced is equivalent to that obtained from four cells. When twelve cells are joined in series-multiple the amperage is equal to that of one cell multiplied by three, while the voltage or current pressure is equal to that produced by one cell multiplied by the number of cells which are in series in any one set. By properly

combining dry cells in this manner, batteries of any desired current strength may be obtained.

The terms "volt" and "ampere" are merely units by which current strength is gauged. The volt is the unit of pressure or potential which exists between the terminals of a circuit. The ampere is a measure of current quantity or flow and is independent of the pressure. One may have a current of high amperage at low potential or one having great pressure and but little amperage or current strength. Voltage is necessary to overcome resistance while the amperage available determines the heating value of the current. As the resistance to current flow increases the voltage must be augmented proportionally to overcome it. A current having strength of one ampere with a pressure of one volt is said to have a value of one watt, which is the unit by which the capacity of generators and the amount of current consumption of electrical apparatus is gauged.

The Master Vibrator System.—One of the most widely advertised accessories intended for the use of Ford car owners is called a "master vibrator"; this consists of a simple primary coil carrying a vibrator intended to serve all of the coil units, the regular vibrators with which these are provided being short circuited so that they do not operate. Opinions regarding the practical utility of a master vibrator differ greatly, some contending that it materially improves the steady operation of the engine while others do not believe that it is of any material benefit. The contention made by those favoring this device is that the use of one vibrator for all coil units provides a spark that will occur in each cylinder at exactly the same time in the cycle of operations, because it reduces the lag that might result from tardy action of

one or more of the individual unit coil vibrators. The argument of greater simplicity of having but one vibrator to adjust at any time is the more reasonable one. The writer did not find it necessary to use a master vibrator or any other of the legion of devices advertised to increase the efficiency of the Ford car. The vibrators of

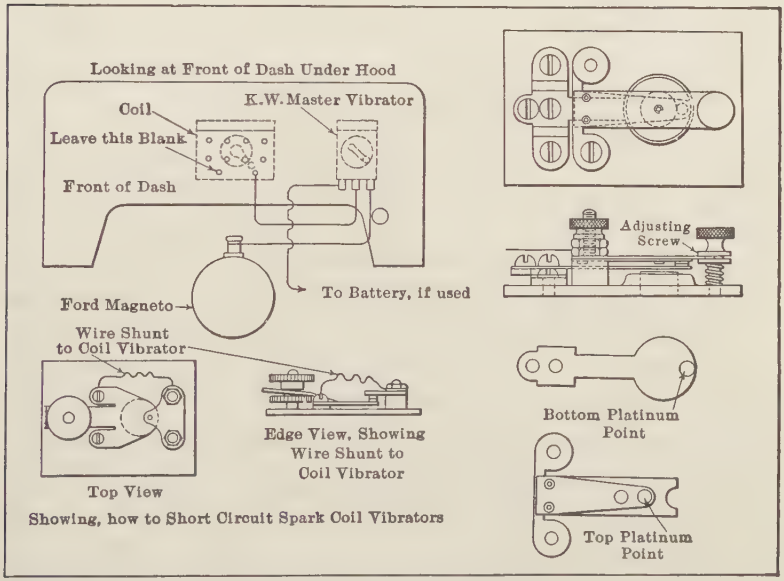

Fig. 23.—Showing Application of Master Vibrator in Ford Ignition System.

the four unit coil regularly provided gave very little trouble, as it was only the work of a few minutes to get all of these adjusted to the point where satisfactory engine action was obtained. The theory of irregular engine action due to lag of a poorly adjusted vibrator on any one of the coil units is only true in cases where the vibrator adjustment has been carried to a point where

it is practically inoperative. The non-mechanical owner who cannot adjust the vibrators furnished on the regular Ford coil properly is not apt to have much success in adjusting that of a master vibrator, inasmuch as faulty adjustment of the one vibrator serving all coil units will throw the entire ignition system out of order, whereas if only one of the four coil units is not properly adjusted the engine will be able to run with some degree of power on the other three units.

As many Ford cars have been fitted with a master vibrator by their owners, these afterward passing into other hands, it may be well for the reader to familiarize himself with the method of installation of this component. The diagram shown in the upper left corner of Fig. 23 shows the way the master vibrator is placed in circuit. The plan and side views below the wiring diagram show the simple method of short circuiting the regular spark coil vibrator by joining the vibrating and fixed portions with a short length of wire. At the right of the illustration are views showing the construction of the master vibrator, depicting the large platinum points necessary when one member serves four coil units, also the means provided for adjustment.

Why Cooling Systems Are Necessary.—The reader should now understand that the power of any internal combustion motor is obtained by the rapid combustion and consequent expansion of some inflammable gas. The operation in brief is that when air or any other gas or vapor is heated, it will expand, and that if this gas is confined in a space which will not permit expansion, pressure will be exerted against all sides of the containing chamber. The more a gas is heated the more pressure it will exert upon the walls of the combustion chamber by which it is

confined. Pressure in a gas may be created by increasing its temperature, and inversely heat may be created by pressure. When a gas is compressed its total volume is reduced and the temperature is augmented. The efficiency of any form of heat engine is determined by the power obtained from a certain fuel consumption. A definite amount of energy will be liberated in the form of heat when a given quantity of any fuel is burned. The efficiency of any heat engine is proportional to the power developed from a definite quantity of fuel with the least loss of thermal units. If the greater proportion of the heat units derived by burning the explosive mixture could be utilized in doing useful work, the efficiency of the gasoline engine would be much greater than that of any other form of power producer.

There is a great loss of heat from various causes, among which can be cited the reduction of pressure through cooling the motor and the loss of the heat through the exhaust valves when the burned gases are expelled from cylinder. The loss through the water jacket of the average automobile power plant is over 50% of the total fuel efficiency. This means that more than half of the heat units that should be available for power are absorbed and dissipated by the cooling water. Another 16% is lost through the exhaust valve, and but 33⅓% of heat units do useful work. The great loss of heat through the cooling systems cannot be avoided, as some method must be provided to keep the temperature of the engine within proper bounds. It is apparent that the rapid combustion and continued series of explosions would soon heat the metal portions of the engine to a red heat if some means were not taken to conduct much of this heat away. The high temperature of the parts would

burn the lubricating oil, even that of the best quality, and the piston and rings would expand to such a degree, especially when deprived of oil, that they would seize in the cylinder. This would score the walls, and the friction which ensued would tend to bind the parts so tightly that the piston would stick, bearings would be burned out, valves would warp, and the engine would soon become inoperative.

The best temperature to secure efficient operation is one on which considerable difference of opinion exists among engineers. The fact that the efficiency of an engine is dependent upon the ratio of heat converted into work compared to that generated by the explosion of the gas is accepted fact. It is very important that the engine should not get too hot, and at the other hand it is equally vital that the cylinder be not robbed of too much heat. The object of cylinder cooling is to keep the temperature of the cylinder below the danger point, but at the same time to have it as high as possible to secure maximum power from the gas burned.

Cooling Systems Generally Applied.—There are two general systems of engine cooling in common use: that in which water is heated by the absorption of heat from the engine and then cooled by air, and the other method in which the air is directed onto flanged cylinders and absorbs the heat directly instead of through the medium of water. When the liquid is employed in cooling it is circulated through jackets which surround the cylinder casting, and the water may be kept in motion by two methods. The one sometimes favored is to use a positive circulating pump of some form which is driven by the engine to keep the water in motion. The other system is to utilize a natural principle that heated water is lighter

than cold liquid, and that it will tend to rise to the top of the cylinder when it becomes heated to the proper temperature and cooler water takes its place at the bottom of the water jacket.

Ford Water Circulation by Natural System.—Some engineers contend that the rapid water circulation obtained

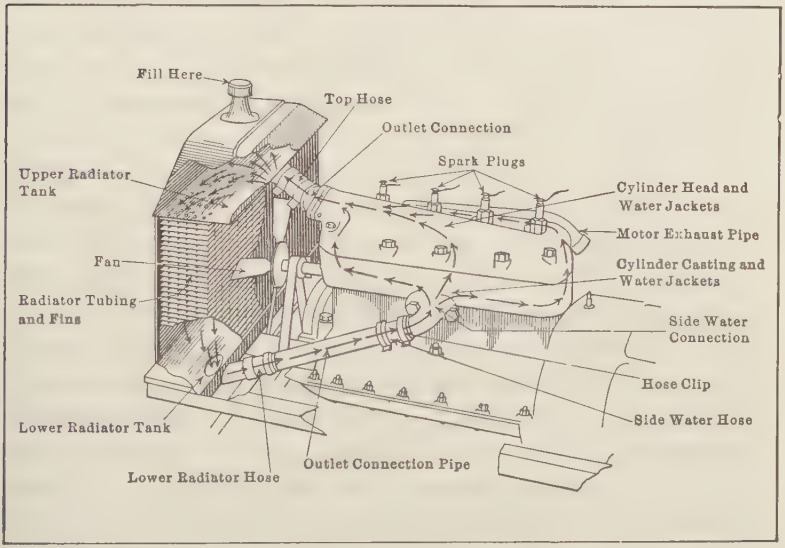

Fig. 24.—The Ford Thermo-Syphon Water Cooling System.

by using a pump may cool the cylinders too much, and that the temperature of the engine may be reduced so much that the efficiency will be lessened. For this reason there is a growing tendency to use the natural method of water circulation as the cooling liquid is supplied to the cylinder jackets just below the boiling point, and the water issues from the jacket at the top of the cylinder after it has absorbed sufficient heat to raise it just about to the boiling point.

The Ford cooling system, depicted at Fig. 24, is very successful in practice, and is somewhat simpler than the forms in which a pump is used to maintain circulation. With this method, the fact that water becomes lighter as its temperature becomes higher is taken advantage of in securing circulation around the cylinders. The top of the water jacket of the block cast cylinder head is attached to the top center of the radiator, while the pipe leading from the bottom of that member is connected to a manifold which supplies cool water to the bottom of the cylinder jacket.

With a thermo-siphon system it is imperative that the radiator be carried at such a height that the cool water will flow to the water spaces around the cylinder by gravity. As the water becomes heated by contact with the hot cylinder and combustion chamber walls it rises to the top of the cylinders, flows to the cooler, where enough of the heat is absorbed to cause it to become sensibly greater in weight. As the water becomes cooler it falls to the bottom of the radiator, and it is again supplied to the water jacket. The circulation is entirely automatic and continues as long as there is a difference in temperature between the liquid in the cooler and that in the jacket. The circulation becomes brisker as the engine becomes hotter, and thus the temperature of the cylinders is kept more nearly to a fixed point. With the thermo-siphon system the cooling liquid is nearly always at its boiling point, whereas if the circulation is maintained by a pump the engine will become cooler at high speed and will heat up more at low speed. So long as the proper quantities of clean water are used in the radiator there is nothing that can interfere with proper engine cooling. There is no pump drive to complicate the con-

struction and demand attention. It is an ideal cooling system for a car designed for use by the masses.

The radiator cools the water by dividing it into a number of fine streams as the liquid passes from the upper portion to the lower tank through a large number of fine copper pipes which are cooled by air currents passing over flanges soldered to them. A belt-driven fan is placed back of the radiator to insure a constant passage of air through the passages between the radiator tubes at all times that the engine is running. When the car is in operation, the air currents are increased in value by added air movement due to natural draft.

Theory of Lubrication.—The reason a lubricant is supplied to bearing points will be easily understood if one considers that these elastic substances flow between the close-fitting bearing surfaces, and by filling up the minute depressions in the surfaces and covering the high spots, act as a cushion which absorbs the heat generated, and takes the wear instead of the metallic surfaces. The closer the parts fit together the more fluid the lubricant must be to pass between their surfaces and at the same time it must possess sufficient body so that it will not be entirely forced out by the pressure existing between the parts. Oils should have good adhesive, as well as cohesive, qualities. The former are necessary so that the oil film will cling well to the surfaces of the bearings; the latter, so the oil particles will cling together and resist the tendency to separation which exists all the time the bearings are in operation.

When used for gas engine lubrication, the oil should be capable of withstanding considerable heat in order that it will not be vaporized by the hot portions of the cylinder. It should have sufficient cold test so that it will

remain fluid and flow readily at low temperature. Lubricant should be free from acid or alkalies, which tend to produce a chemical action with metals and result in corrosion of the parts to which they are applied.

It is imperative that the oil be exactly the proper quality and nature for the purpose intended, and that it be applied in a positive manner. The requirements may be briefly summarized as follows: First—It must have sufficient body to prevent seizing of the parts to which it is applied and between which it is depended upon to maintain an elastic film, and yet it must not have too much viscosity in order to minimize the internal or fluid friction which exists between the particles of the lubricant itself. Second—The lubricant must not coagulate or gum, must not injure the parts to which it is applied, either by chemical action or by producing injurious deposits, and it should not evaporate readily. Third—The character of the work will demand that the oil should not vaporize when heated moderately, or thicken to such a point that it will not flow readily when cold. Fourth—The oil must be free from acid, alkalies, animal or vegetable fillers or other injurious agencies. Fifth—It must be carefully selected for the work required and should be a good conductor of heat.

Derivation of Lubricants.—The first oils which were used for lubricating machinery were obtained from animal and vegetable sources, though at the present time most of them are of mineral derivation. Lubricants may exist as fluids, semi-fluids, or solids. The viscosity will vary from spindle or dynamo oils, which have but little more body than kerosene, to the heaviest greases and tallows. The most common solid employed as a lubricant is graphite, sometimes termed "plumbago" or "black

lead." This substance is of mineral derivation. Soapstone is also a lubricant, and is used in tires. The disadvantage of oil of organic origin, such as those obtained from animal fats or vegetable substances, is that they will absorb oxygen from the atmosphere which causes them to thicken or become rancid. Such oils have a very poor cold test, as they solidify at comparatively high temperatures and their flashing points are so low that they cannot be used at points where much heat exists. In most animal oils various acids are present in greater or less quantities, and for this reason they are not well adapted for lubricating metallic surfaces which may be raised high enough in temperature to cause decomposition of the oils.

Lubricants derived from the crude petroleum are called "Oleonaphthas," and they are a product of the process of refining petroleum through which gasoline and kerosene are obtained. They are of lower cost than vegetable or animal oils, and as they are of non-organic origin they do not become rancid or gummy by constant exposure to the air, and they will have no corrosive effect on metals because they contain no deleterious substances in their chemical composition. By the process of fractional distillation mineral oils of all grades can be obtained. They have a lower cold and higher flash test, and there is not the liability of spontaneous combustion that exists with animal oils.

The importance of minimizing friction at the various bearing surfaces of machines to secure mechanical efficiency is fully recognized by all mechanics, and proper lubricity of all parts of the mechanism is a very essential factor upon which the durability and successful operation of the motor car power plant depends. All of the moving members of the engine which are in contact with other

portions, whether the motion is continuous or intermittent, of high or low velocity or of rectilinear or continued rotary nature, should be provided with an adequate supply of oil. No other assemblage of mechanism is operated under conditions which are so much to its disadvantage as the motor car, and the tendency is toward a simplification of oiling methods so that the supply will be ample and automatically applied to the points needing it.

In all machinery in motion the members which are in contact have a tendency to stick to each other, and the very minute projections which exist on even the smoothest of surfaces would adhere to each other if the surfaces were not kept apart by some elastic and unctuous substance. This will flow or spread out over the surfaces and smooth out the inequalities existing which tend to produce heat and retard motion of the pieces relative to each other.

How Ford Power Plant Is Lubricated.—The system of lubrication employed in the Ford power plant is an exceptionally simple one, requiring no apparatus other than that regularly forming a part of the engine. The construction of the magneto has been previously described, and mention made of the way the magnets are attached to the flywheel rim. These magnets also serve as a portion of the lubrication system being employed to circulate the oil. If one will refer to the part sectional view at Fig. 11, it will be apparent that a series of troughs are placed on the center line of each cylinder in the bottom plate, these being so arranged that as the connecting rods rotate the big ends dip into the troughs and scoop out some of the oil present in these members, throwing it about the engine interior and lubricating all parts exposed to the spray. It will be evident that all internal

parts of the engine will be oiled continuously if some means is provided for keeping these troughs or channels full of lubricant.

This object is attained in a very simple manner by filling the flywheel compartment of the engine crank case to a definite height which is indicated by small drain cocks placed on the back side of the lower crank case compartment. This level is sufficiently high so the magnets are partially submerged in the oil as the flywheel revolves. It will be apparent that considerable oil will be scooped up by the projecting magnets, and these are utilized to lift oil into a small funnel attached to the side of the crank case and in the path of the oil stream. This funnel communicates with a brass tube that conveys the stream of lubricating oil to the front crank case compartment housing the timing gears. From this point the oil drains back, filling the troughs until they overflow, the surplus then flowing back into the flywheel compartment of the crank case. This system of lubrication also provides for thorough lubricity of the exposed planetary transmission gears carried in the gear case, which really forms the rear part of the engine crank case.

The oil is introduced into the engine through an opening obtained by removing the brass cover of the breather pipe. When the Ford engine is new and all crank case joints are tight so there is no leakage, the oil consumption will be equivalent to about one quart per hundred miles of car operation. The makers advise keeping the oil level at a point about midway between the two petcocks, but how this can be determined without the use of the X-ray can only be conjectured. They advise that carrying the oil level above the top petcock will result in excessive use of lubricant, whereas having the level below

the lower petcock will be apt to result injuriously, owing to lack of lubrication. However, it is better to use too much oil than not enough, so most Ford owners fill the flywheel compartment to the height indicated by the top drain cock. Simple glass gauge fittings may be procured from accessory dealers by which the height of oil may be accurately gauged. These replace the lower petcock, and many Ford owners find it desirable to purchase this inexpensive fitting, as the level of the oil may be determined at a glance. During practically all the time that the writer had his car in operation, it was his rule to supply one quart of oil through the breather pipe for every five gallons of gasoline that was placed into the fuel tank. Then, the top petcock was opened until the surplus lubricant had drained out. With the Ford system of lubrication it is necessary to remove the crank case oil plug at the bottom of the flywheel compartment and drain out the old oil at least every five hundred miles, flushing out the interior of the crank case thoroughly with gasoline or kerosene and introducing enough lubricant after the oil plug had been replaced to bring the level to the proper height.

The Ford Muffler.—When the exhaust gas of a gasoline engine is discharged into the open air directly from the valve ports, each discharge is accompanied by a sound resembling a gunshot. Evidently this would be very annoying to the public, so means are taken to silence the exhaust gases before they are discharged to the outer air. The Ford muffler, which is illustrated at Fig. 25, is a very simple assembly that silences the gas by permitting it to expand to a point where it is practically at atmospheric pressure before it is discharged to the air. The muffler is attached to one of the chassis side members,

and is connected to the exhaust manifold attached to the cylinder casting by a piece of steel tubing. The muffler consists of two end castings having cylindrical ledges cast integrally which are used as supports for the concentric tubular members which divide the muffler into three distinct compartments. The gas from the exhaust pipe passes first into the central compartment, which is but slightly larger than the exhaust pipe. A number of passages or

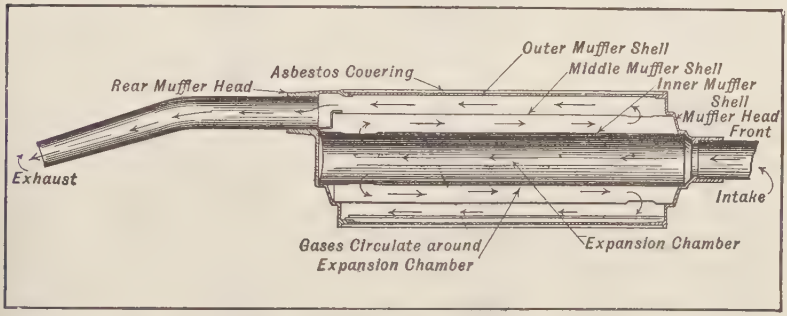

Fig. 25.—Sectional View Defining Construction and Method of Operation of the Ford Exhaust Gas Silencer.

slots are pierced through the rear end of this chamber. The gas is discharged through the slots into the intermediate chamber, passing from this to the outer chamber through a series of openings at the front end of the middle muffler shell. The outer muffler shell serves as a casing for the assembly, and is covered with a sheet of asbestos which not only serves to muffle the sound made when the gas is discharged into the muffler, but which also serves to keep the heat of the muffler properly confined. The gas from the outer expansion chamber, which is formed by the space between the middle and outer muffler shells, issues to the air through a discharge pipe.

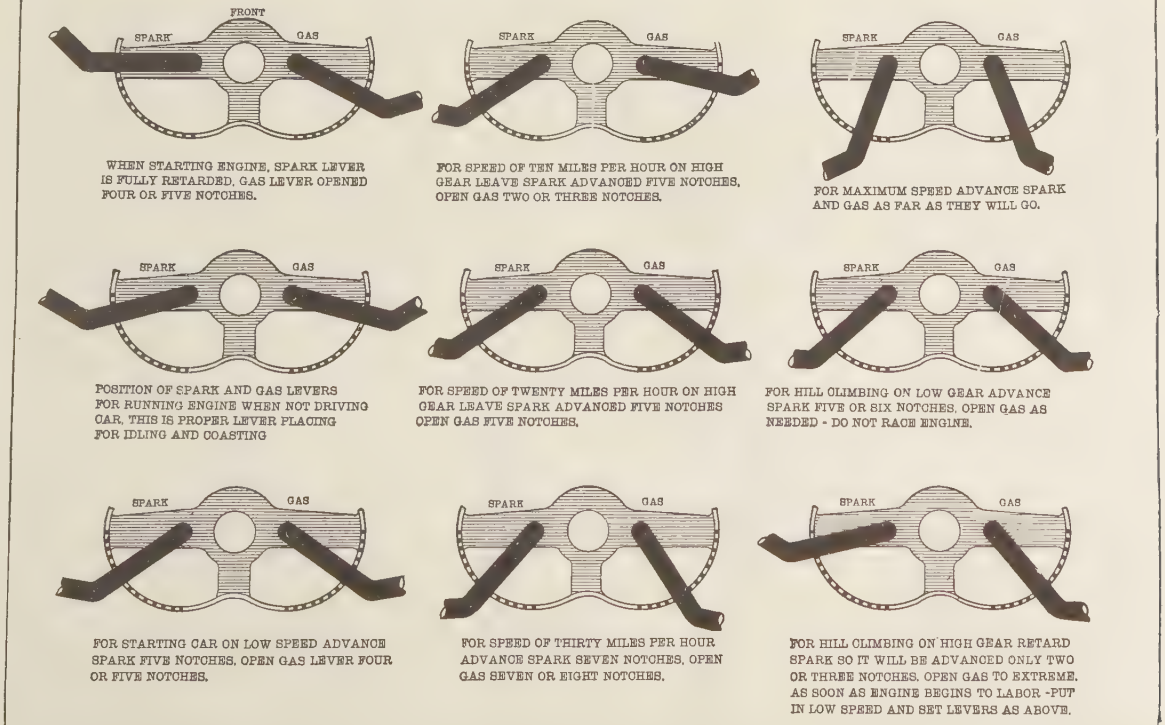
FRONT
SPARK
GAS
WHEN STARTING ENGINE, SPARK LEVER IS FULLY RETARDED, GAS LEVER OPENED FOUR OR FIVE NOTCHES.
FOR SPEED OF TEN MILES PER HOUR ON HIGH GEAR LEAVE SPARK ADVANCED FIVE NOTCHES, OPEN GAS TWO OR THREE NOTCHES.
FOR MAXIMUM SPEED ADVANCE SPARK AND GAS AS FAR AS THEY WILL GO.
POSITION OF SPARK AND GAS LEVERS FOR RUNNING ENGINE WHEN NOT DRIVING CAR, THIS IS PROPER LEVER PLACING FOR IDLING AND COASTING
FOR SPEED OF TWENTY MILES PER HOUR ON HIGH GEAR LEAVE SPARK ADVANCED FIVE NOTCHES OPEN GAS FIVE NOTCHES.
FOR HILL CLIMBING ON LOW GEAR ADVANCE SPARK FIVE OR SIX NOTCHES, OPEN GAS AS NEEDED - DO NOT RACE ENGINE.
FOR STARTING CAR ON LOW SPEED ADVANCE SPARK FIVE NOTCHES, OPEN GAS LEVER FOUR OR FIVE NOTCHES.
FOR SPEED OF THIRTY MILES PER HOUR ADVANCE SPARK SEVEN NOTCHES, OPEN GAS SEVEN OR EIGHT NOTCHES.
FOR HILL CLIMBING ON HIGH GEAR RETARD SPARK SO IT WILL BE ADVANCED ONLY TWO OR THREE NOTCHES. OPEN GAS TO EXTREME. AS SOON AS ENGINE BEGINS TO LABOR -PUT IN LOW SPEED AND SET LEVERS AS ABOVE.

Fig. 38. Chart Showing Positions of Engine Control Levers on Steering Post Quadrants for Various Conditions of Car Operation. These are the Average Positions and May Vary Slightly on Different Ford Cars.

CHAPTER III

DETAILS OF THE FORD CHASSIS PARTS

Why Clutch is Necessary—How Friction Clutches Transmit Power—Why Change Speed Gearing Is Needed—How Ford Planetary Gearing Operates—Method of Power Transmission—Rear Axle Construction—The Ford Axle Bearings—Purpose of Differential Gear—Utility of Motor Car Brakes—The Ford Steering Gear.

Next in importance to the power plant and its auxiliary groups are those chassis parts which have to do with the delivery of power from the engine crank shaft to the rear wheels. These parts are usually called the transmission members, and while they are not apt to give much trouble except to depreciate from natural wear as the car is used, it is well for the reader to become familiar with the method of operation and the relation the transmission parts bear to the other chassis components. The most important member, and one that is always in use, is the drive shaft which takes the engine power from the rear end of the transmission or change speed gearing to the bevel gears mounted in the rear axle which imparts motion to the wheels.

The parts comprising the transmission system are the clutch, the change speed gearing, the drive shaft, bevel driving gears, and the axle shafts which turn the wheels, these being carried by the rear construction. In considering the various parts, it will be well to define the reason why a clutch and change speed gearing are needed with a gasoline engine propelled automobile before describing the construction and operation of the Ford clutch and

planetary gearing. In cars employing a sliding gear set the clutch is a separate member from the change speed gear, but in the Ford it forms an integral part of the mechanism depended on to obtain the two forward speeds and reverse ratios. The clutch and change speed gearing is mounted in an extension of the engine crank case, this insuring absolute alignment with the engine crank shaft.

Why Clutch Is Necessary.—In order to secure a better understanding of the general requirements of clutching devices, it will be well to consider the conditions which make their use imperative when an automobile is propelled by a hydrocarbon motor. If either a steam engine or an electric motor are installed as prime movers, it is not necessary to include any clutching device or gear set between them and the driving wheels, and these members may be driven directly from the power plant, if desired. With either of the forms mentioned the power is obtained from a separate source which may be disconnected from the motor by the simple movement of a throttle valve or switch lever. Steam or electric motors are also capable of delivering power in excess of their rating, and are more flexible than internal combustion power plants.

If steam is the motive agent it is generated and contained in a special device, as a boiler, and the amount of power delivered by the engine to which the boiler is connected will vary with the amount of steam admitted and its pressure. If the steam supply is interrupted entirely, the engine and the car which it drives is brought to a stop. When it is desired to start again, a simple movement of the throttle-valve lever will permit the steam to flow from the boiler to the engine cylinders again, and the vehicle is easily set in motion. If it is desired to reverse the car, the steam flow is reversed by a simple

mechanical movement and the engine will run in the opposite direction to that which obtains when the car is driven in a forward direction.

If an electric motor drives a vehicle, the electrical energy is obtained from a group of storage batteries. When these are fully charged varying amounts of electric current may be drawn from them and allowed to flow through the windings of the field or armature of the motor and different ratios of power or speed obtained. The vehicle is easily started by completing the circuit between the motor and the source of current and stopped by interrupting the supply of electrical energy. As the flow of electricity can be reversed easily by a switch, the car may be driven backward or forward at will, and as the speed may be easily varied by changing the value of the current strength there is no need of speed changing or reversing gears.

When a gasoline engine is fitted, conditions are radically different than with either a steam or electric power plant. The power developed depends upon the number of explosions per unit time and the energy augments directly as the number of explosions and revolutions of the crank shaft increase up to a certain point. It is not possible to start a gasoline engine under full load because the power is obtained by the combustion of fuel directly in the cylinder, and as there is no external source of power to draw from, it is obvious that the energy derived depends upon the rapidity with which the explosions follow each other. It has been demonstrated that a certain cycle of operation is necessary to secure gasoline-engine action, and it is imperative that the engine revolves freely until it attains sufficient speed to supply the torque or power needed to overcome the resistance

that tends to prevent motion of the car before it can be employed in driving the vehicle.

Then, again, it is very desirable that the vehicle be started or stopped independently of the engine. With a steam or electric motor the vehicle may be started just as soon as the driving power is admitted to the prime mover, but with a gasoline engine it is customary to interpose some device between the engine and the driving wheels which make it possible to couple the engine to the wheels or driving gearing and disconnect it at will. The simplest method of doing this is by means of some form of clutching device which will lock the rear wheel driving shaft to the crank shaft of the engine.

Clutch Forms and Their Requirements.—Clutch forms that have been applied to automobile propulsion are usually of the frictional type, though some have been devised which depend upon hydraulic, pneumatic, or magnetic energy. Those which utilize the driving properties of frictional adhesion are most common, and have proven to be the most satisfactory in practical application. The most important requirement in a clutch is that this device be capable of transmitting the maximum power of the engine to which it is fitted without any power loss due to slipping. A clutch must be easy to operate and but minimum exertion should be required of the operator. When the clutch takes hold, the engine power should be transmitted to the gears and driving wheels in a gradual and uniform manner or the resulting shock may seriously injure the mechanism. When released it is imperative that the two portions of the clutch disengage positively, so that there will be no continued rotation of the parts after the clutch is disengaged. The design should be carefully considered with a view of providing as much friction

surface as possible to prevent excessive slipping and loss of power. It is very desirable to have a clutch that will be absolutely silent whether engaged or disengaged. If the clutch parts are located in an accessible manner it may be easily removed for inspection, cleaning, or repairs. It is desirable that adjustment be provided, so a certain amount of wear can be compensated for without expensive replacement. A simple, substantial design, with but few operating parts, is more to be desired than a more complex device which may have a few minor advantages, but which is more likely to cause trouble.

The friction clutch in its various efficient types is the one that more nearly realizes the requirements of the ideal clutch. As a result this form is now universally recognized by automobile designers, and all standard gasoline automobiles utilize some form of friction clutch which is included with the planetary speed reduction gearing on the Ford car. These devices are capable of transmitting any amount of power if properly proportioned, and permit of gradual engagement and positive disconnection. Most friction clutches are simple in form, easily understood, and may be kept in adjustment and repair without difficulty.

How Friction Clutches Transmit Power.—To illustrate the transmission of power by the frictional adhesion of substances with each other we can assume a simple case of two metal disks or plates in contact, the pressure existing between the surfaces being due to the weight of one member bearing upon the other. If the disks are not too heavy, it will be found comparatively easy to turn one upon the other, but if weights are added to the upper member, a more decided resistance will be felt which will increase directly as the weight on the top disk, and con-

sequently the pressure between the disks, increases. It may be possible to add enough weight so it will be practically impossible to move one plate without turning the other. It is patent that if one of these plates was mounted rigidly on the engine shaft and one applied to the transmission shaft so that it had a certain amount of axial

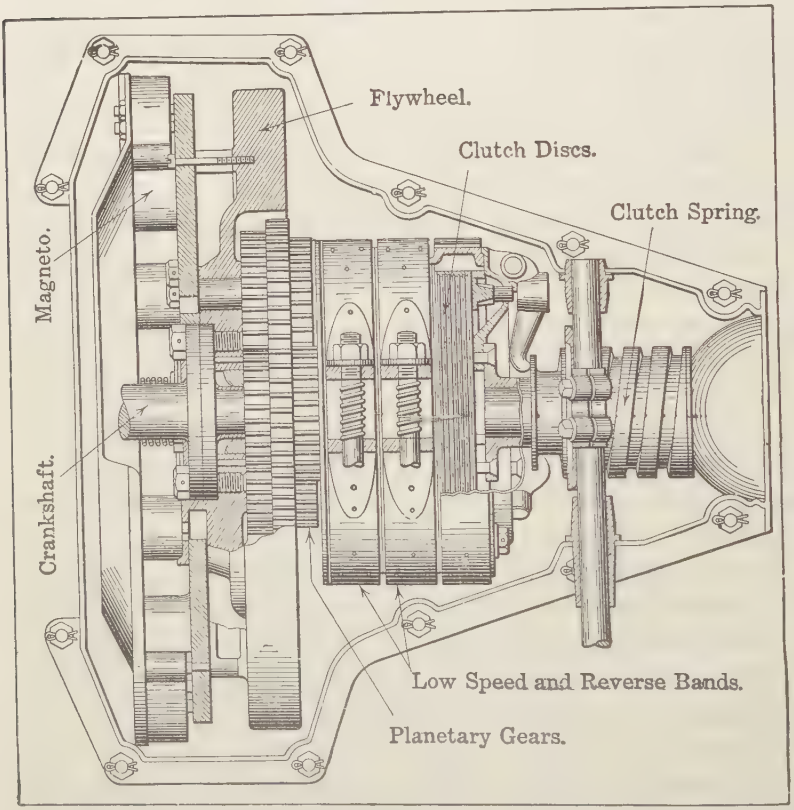

Fig. 26.—Plan View of the Ford Planetary Gearing Showing Method of Carrying Triple Planetary Spur Pinion Assemblies and Actuating the High Speed Disc Clutch Assembly.

freedom and pressure of contact was maintained by a spring instead of weights, a combination capable of transmitting power would be obtained. The spring pressure applied to one disk would force it against the other, and one shaft could not turn without producing a corresponding movement of the other. The Ford clutch, shown at Fig. 26 is a multiple disk form.

Why Change Speed Gearing is Needed.—Those who are familiar with steam or electricity as sources of power for motor vehicles may not understand the necessity for the change speed gearing which is such an essential component of the automobile propelled by internal combustion motors. In explaining the reason for the use of the clutch it has been demonstrated that steam or electric motors are very flexible, and that their speed, and consequently the power derived from them, could be varied directly by regulating the amount of energy supplied from the steam boiler or the electric battery, as the case might be. If, for example, we compare the steam engine with the explosive type, it will be evident that the power is produced in the former by the pressure of steam admitted to the cylinders as well as the quantity and the speed of rotation. When the engine is running slowly and a certain amount of power is needed, more steam can be supplied the cylinder, and practically the same power obtained, as though the steam pressure was reduced and the engine speed increased. The internal combustion motor is flexible to a certain degree, providing that it is operating under conditions which are favorable to accelerating the motor speed by admitting more gas to the cylinders. There is a definite limit, however, to the power capacity or the effective pressure of the explosion, and beyond a certain point it is not possible to increase the

power by supplying vapor having a higher pressure as is possible with a steam engine.

In an explosive motor we can increase the power after the maximum explosive pressure has been reached only by augmenting the number of revolutions. Whereas it is possible to couple a steam engine or an electric motor directly to the shafts driving the wheels, it is not possible to do this with gasoline engines, and some form of gearing must be introduced between the motor and the driving wheels in order that the speed of one relative to the other may be changed, as desired, and the engine crank shaft turned at speeds best adapted to produce the power required, and to allow the rear wheels to turn at speeds dictated by the condition of the roads or the gradients on which the car is operated. It is customary in all automobiles of the gasoline-burning type, where combustion takes place directly in the cylinders, to interpose change speed gearing which will give two or more ratios of speed between the engine and the road wheels. As it is not possible to reverse the automobile engine utilized in conventional cars, it is necessary to add a set of gears to the gear set to give the wheels a reverse motion when it is desired to back it.

How Planetary Gearing Operates.—The planetary or epicycle transmission is an easily operated form of speed gear that has been very popular on small cars. This has many features of merit; it provides a positive drive, and as the gears are always in mesh these members cannot be injured by careless shifting. Individual clutches are used for speed selection, and as the operation of the clutch occurs at the same time that the desired speed is selected, any of the various speed changes desired may be easily effected by manipulating a single hand lever or pedal.

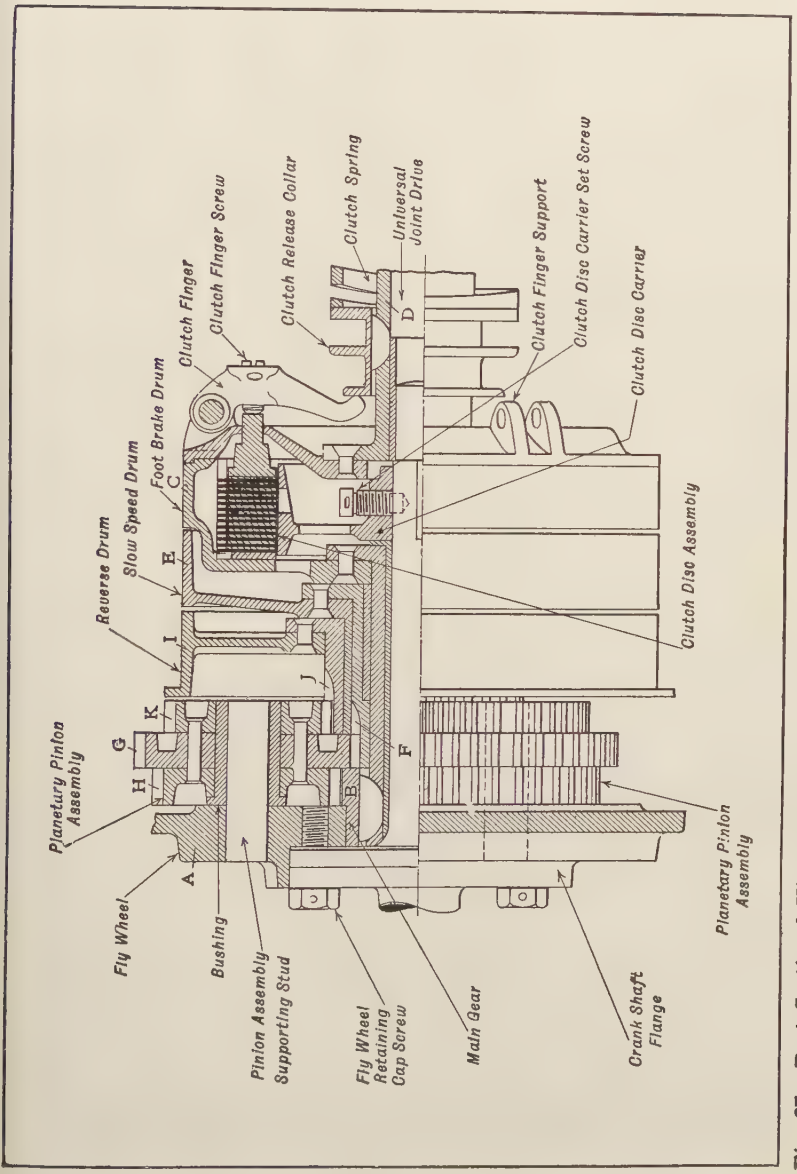

Fig. 27.—Part Sectional View of the Ford Planetary Gearing Showing the Relation of the Planetary Pinion Assembly, the Reverse, Slow Speed and Foot Brake Drums and the Clutch Disc Assembly.

The planetary gearing shown at Fig. 27 is that used in Ford automobiles, and its operation is as follows: This contains only spur pinions. The flywheel web, A, serves as pinion carrier and driving member, having three lateral studs secured into it which carry triple planetary pinions. Gear B is the driven member, being keyed to the hub clutch drum C, which in turn is secured to driven shaft D. By applying a brake band to drum E, gear F is held stationary, pinion G rolls on it, and the smaller pinion H causes gear B to turn slowly in the same direction as pinion carrier A. By applying a brake band to drum I, gear J is held stationary, pinion K rolls on it, and the larger pinion H turns gear B slowly in the reverse direction. For the high gear, or direct drive, the friction clutch locks clutch drum C to the engine tail shaft, and the entire gear mechanism rotates as a unit. In this mechanism the master clutch, which provides the direct drive, is a multiple-disk form composed of two sets of steel disks, which are kept in contact and proper driving relation by means of a heavy coiled spring. The low and reverse speeds are obtained in the conventional manner by tightening the external contracting clutch bands, which are shown between the gearing and disk clutch in Fig. 28. One set of the high speed clutch plates drive the drum C, and are driven by the other set which are keyed to the clutch disk carrier rotated by the engine crank shaft extension.

Planetary gearing has been very successful when properly designed and installed, and its chief disadvantage is that it is very difficult to provide more than two forward speeds and one reverse. For this reason it can only be adapted to light cars which have a surplus of power in the engine as the Ford. While such gearing is not very

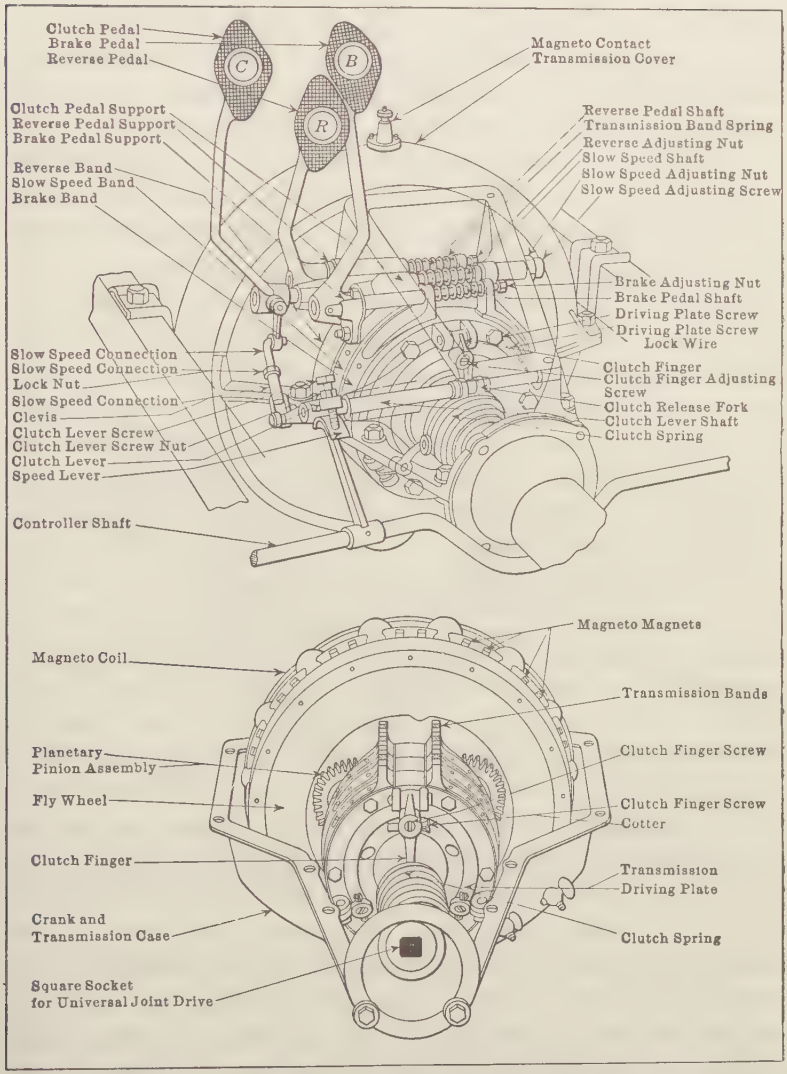

Fig. 28.—Phantom View of the Ford Planetary Gearset Showing the Control Pedal Assembly at Top. View of Gearing Partially Disassembled Showing Brake Bands and Other Parts at the Bottom.

efficient on low and reverse speeds as considerable power is absorbed in friction, on the high speed or direct drive it is superior to any other form of change-speed gearing because the entire assembly is locked to the crank shaft, no gears are turning idly and the weight of the gearing serves merely as an additional flywheel member. With light cars like the Ford practically all roads may be negotiated on the direct drive and the low speed is very seldom used. Considerable trouble was experienced with the early forms because it was difficult to keep oil in the case, but in the Ford design special care has been taken in housing the reduction gears so these are constantly oiled, and both wear and noise, which were formerly detrimental to the adoption of this form of gearing and which militated largely against its general use, have been eliminated to a large extent.

Method of Power Transmission.—The power delivered to the gear set from the motor crank shaft is taken by means of the universal joint and propeller shaft to bevel gearing forming part of the rear axle. This driving gearing is shown at Fig. 29 while a sectional view showing the arrangement of the rear axle parts is presented at Fig. 30. The propeller shaft is enclosed in a drive shaft tube which also acts as a torque member to resist the tendency of the rear axle to rotate while the wheels are driving the car or when the hub brakes are applied to stop the car. This tube terminates in a universal joint casing made in the form of a ball with a portion cut off the top, this fitting in a suitable carrying member or ball seat, machined in the back end of the transmission case. The front end of the propeller shaft revolves in a plain bearing, while the rear end which carries the bevel driving pinion is supported by a flexible roller bearing. The bevel

pinion meshes with a large bevel gear, often called the "ring gear," which is attached to the differential housing in the manner indicated at Fig. 29. A portion of the differential housing is cut away in this illustration to show the method of carrying the differential pinions and

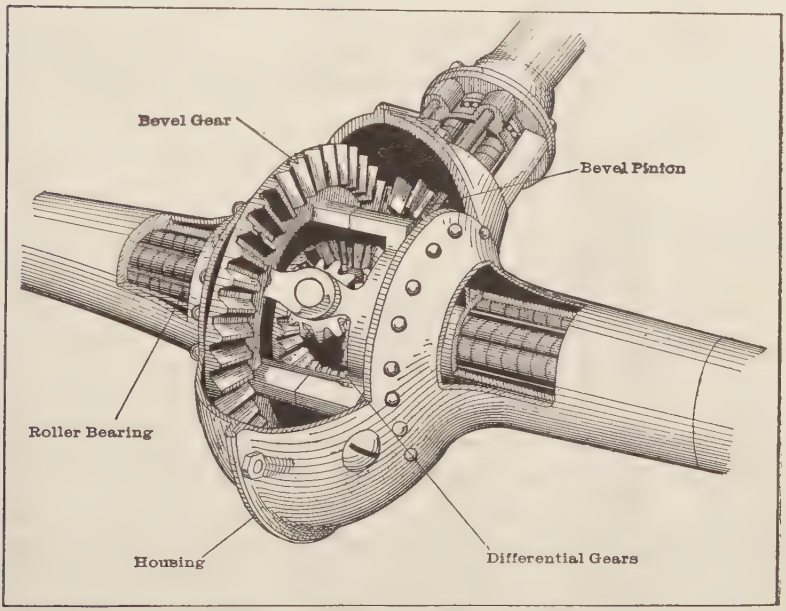

Fig. 29.—Cutaway View of the Ford Rear Axle Differential Housing Showing Arrangement of Bevel Driving Gearing and Differential Gears.

the way these are in mesh with the differential gears attached to the wheel driving axle shafts. Part of the axle housing is also cut away on each side to show the roller bearings which may be more clearly seen in the sectional view of entire rear construction at Fig. 30. When the motor is operating and the low or high speed is engaged,

the universal joint and the shaft to which it is attached turn clockwise when viewed from the front of the car. In other words this shaft revolves in the same direction as the crank shaft of the motor though its speed of rotation depends on whether the low speed band or the high speed clutch is engaged.

With the low speed engaged the engine shaft is turning faster than the drive shaft, though with the high speed clutch transmitting the power the propeller shaft and engine crank shaft turn at the same speed. The power then goes through the universal joint and the shaft to which the bevel pinion is attached, from this to the large ring gear attached to the differential casing and from the differential mechanism to the axle shafts connected to the road wheels. When the engine is turning clockwise, the large gear turns forward, as do the axles and wheels attached to them, and as a result the car will move in a forward direction. When the reverse motion control pedal is depressed and the reverse friction band is constricted around the reverse drum of the gearing the gears previously described come into action, thus reversing the motion of the universal joint and pinion drive shaft causing the large gear in the rear axle to turn in a direction opposite to that obtained when either the high or low speeds are in action and thus producing a backward motion of the car.

It will be apparent that there is considerable difference in the size of the drive gears, the bevel pinion being much smaller than the ring gear attached to the differential. This is done because the ring gear must turn slower than the engine crank shaft, as it would not be practical to rotate the road wheels at a speed equal to that of the engine crank shaft because the resistance to car move-

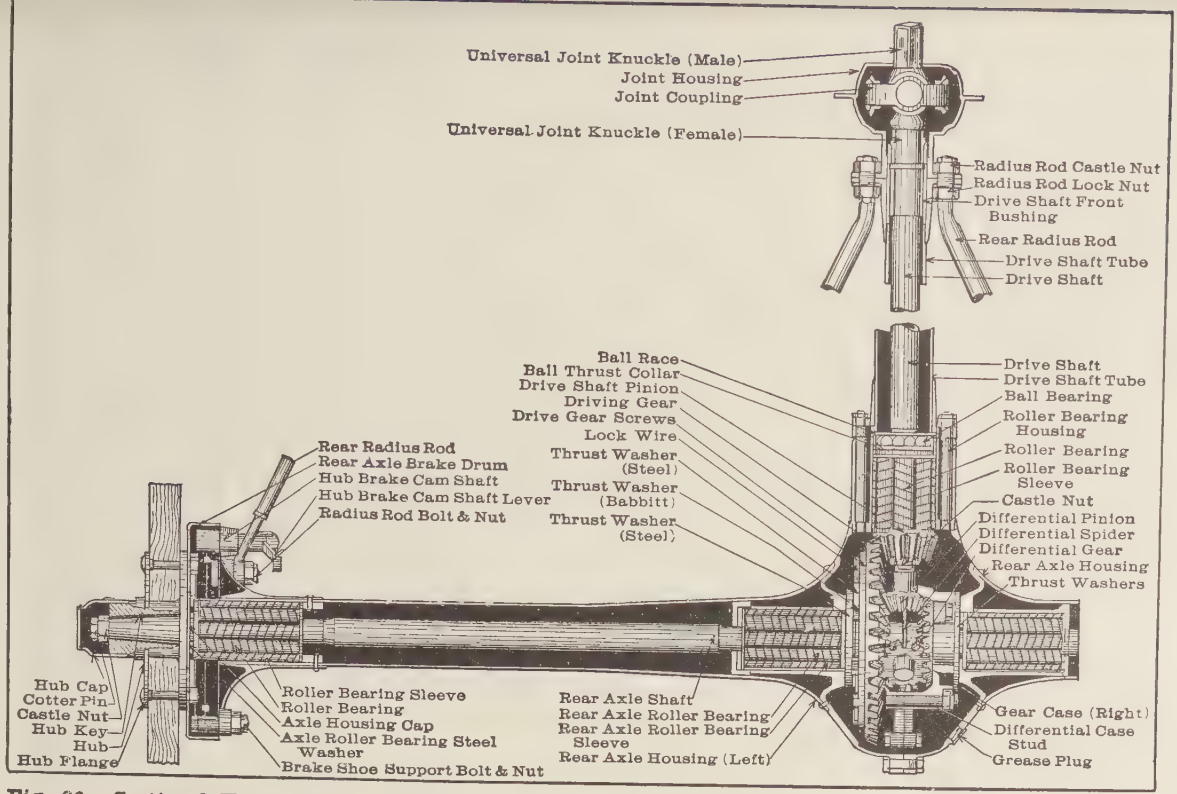

Fig. 30.—Sectional View of Ford Model T Rear Axle Showing Driving Gears, Differential, Power Transmission Shafts and Supporting Bearings.

ment is too great to be overcome by such a direct application of power. The bevel pinion is provided with eleven teeth and the large gear it drives has forty teeth. Consequently, the driving shaft and its pinion will make 3⅔₁₁ revolutions for every one of the large gear when the high speed clutch or direct drive is engaged. When the low speed is brought into action the reduction is considerably increased by the gears in the transmission. In this case, the engine crank shaft will make about ten revolutions to one of the rear wheels.

One of the important elements of the driving system is the universal joint which is a flexible, though positive driving coupling that permits rotating the driving shaft even though that member is at an angle with the engine crank shaft. This slope is made necessary because the differential and drive gearing in the rear axle are carried lower than the gear set, so it will be apparent that it is necessary to provide some driving coupling that is capable of compensating for this lack of alignment. The universal joint is composed of three main parts, two knuckle joints and a joint ring. The ring is made in two half sections riveted together which serve as a bearing for the male and female knuckle joint driving pins. As will be noted by consulting Fig. 30, the male knuckle joint is so called because it has a squared end intended to slip into a square machined in the transmission shaft. The boss of the female knuckle joint is in the form of a sleeve formed to slip over the end of the driving shaft and secured thereto by a pin passing through both. The square end of the male joint may move back and forth in the transmission shaft to compensate for any slight end movement that may be present as the universal joint ring member rocks on the knuckle joint pins. The universal joint is housed in

the globular member indicated, which is filled with lubricant to provide for thorough oiling of the moving parts.

The rear construction, as the entire rear axle assembly is called, supports the rear end of the chassis and in turn is supported by the road wheels. These are members somewhat similar in design to certain forms of carriage wheels, the wooden spokes being mounted between hub flanges at the central part of the wheel and forced into a wooden felloe band to which the tire-carrying rim is attached at the outer ends. The rear wheel flanges are of metal and they are securely attached to a central hub member which is bored tapering to fit the tapered end of the drive axle. The axle is provided with a key which fits a keyway in the hub member and when the wheel hub is clamped on the axle taper by the retention nut the wheel cannot turn unless the axle turns with it. As a result when the energy of the motor is applied to the driving axles through the medium of the differential gear the road wheels must rotate with them. The wheel is prevented from backing off of the taper by a suitable clamp nut which in turn is locked in place by a split pin which passes through the axle and which fits into slots milled across the end of the nut. The rear wheel hubs carry a pressed steel brake drum which is retained by the same bolts holding the wheel assembly together. This drum serves to house the emergency brake shoes and their operating cams. The rear construction therefore consists of three casings or housing members, one serving to carry the propeller shaft while the other two are bolted together to form the housing for the axle shafts carrying the wheels and the differential and driving gear mechanism.

The Ford Axle Bearings.—Careful study of the cutaway view of the differential housing at Fig. 29 and of the rear

axle assembly at Fig. 30 will show that the various driving shafts are supported by anti-friction bearings at all points subjected to heavy loads. For example, the driving shaft is supported at the universal joint-end by a plain bushing which answers the purpose because it serves

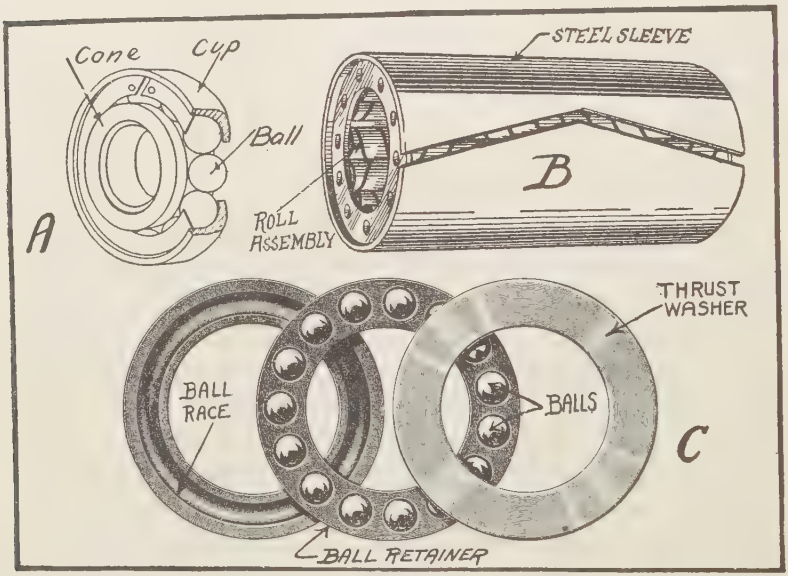

Fig. 31.—Types of Anti-Friction Bearings Used in the Ford Car. A—Cup and Cone Type Angular Contact Ball Bearings Similar to Those Used in the Front Wheels. B—Hyatt Flexible Roller Bearing. C—Special Ball Bearings for Resisting End Thrust Only.

merely to guide the shaft and is not subject to any great stress. At the pinion end, however, the load is greater and a plain bearing would wear out very quickly, besides consuming a lot of power all the time it was in use. The pinion end of the driving shaft, therefore, is fitted with a large flexible roller bearing and a ball thrust bearing.

The function of this thrust bearing is to compensate for the tendency to end movement of the driving shaft which results because of the angularity of the faces of the bevel driving gearing. When the motor is propelling the car, the driving reaction on the angular teeth of the ring gear produces a decided end thrust against the pinion shaft. The roller bearing which is utilized to take care of the radial load or to prevent side movement of the shaft is not capable of withstanding this end thrust so a special ball thrust bearing must be provided to assist the roller bearing to preserve the proper relation between the driving pinion and the ring gear. All wheels of the Ford car are carried by anti-friction bearings. The front wheels are mounted on cup and cone ball bearings of the general type shown at A, Fig. 31, their practical application being shown at Fig. 32. This form of bearing consists of a pressed steel cup member forced into the hub shell casting and a cone member fitting the axle spindle tightly. The space between the cup and cone is filled with steel balls which carry the load with a rolling motion and thus have much less friction than a plain bearing in which the surfaces must slide over each other.

The differential mechanism and the wheel end of the axle utilize roller bearings of the general form shown at Fig. 31, D. This bearing consists of a cage carrying a number of spiral rollers which roll on the steel shaft but which do not bear directly against the housing tube as a steel sleeve is introduced to form a track for the rollers to run on. The ball thrust bearing which is used at the front end of the roller bearing supporting the pinion end of the propeller shaft is of the general form shown at Fig. 31, C. In this bearing the raceways have grooved ball tracks formed on their faces, the balls being placed between them

in such a way that the bearing is suitable only to take loads coming from a direction approximately parallel with the driving shaft. These loads are called end thrusts while loads applied at right angles to the driving shafts, as, for example, the weight load on the roller bearings at the wheel end of the axle are termed radial loads. As a

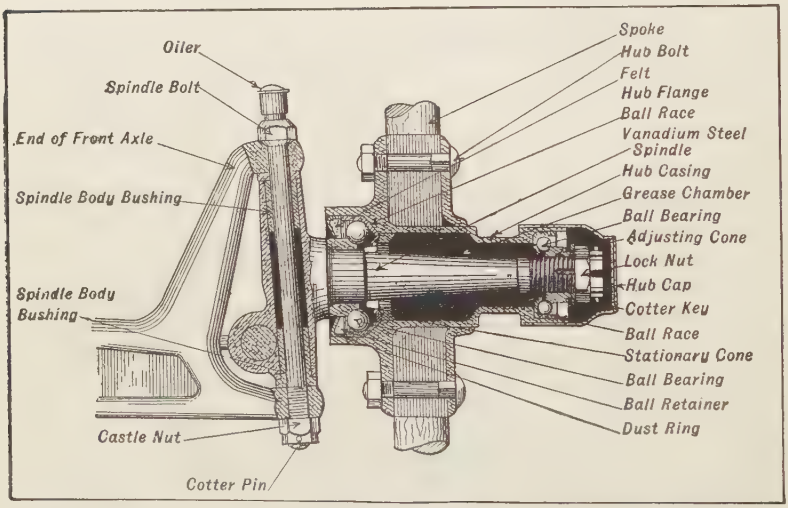

Fig. 32.—Sectional View of Ford Front Wheel Hub Showing Method of Installing Cup- and Cone- Type Ball Bearings.

roller bearing consumes less power than a plain bearing and as they are more enduring and require less attention as well as being inexpensive, the entire axle and differential assembly is carried by roller bearings.

Each axle shaft revolves in two roller bearings, one being placed near each side of the differential and one at each of the outer ends of the drive axle housing near the wheel. The roller bearing consists of a group of hardened steel rollers in the form of close wound coil springs which

are prevented from coming in contact with each other by a cage or retainer which is clearly shown at Fig. 31, B. It will be apparent that the outer bearings or those at the wheel end of the axle carry practically all of the radial load due to car weight and driving strains. To compensate for end thrust on the wheel drive axles, such as is present when the wheels skid, thrust bearings are provided at each side of the differential gear case. The axle shafts cannot move outward because they are securely keyed to the differential gear members, these transferring any of the thrust load to babbit metal rings carried at each side of the differential housing which in turn are sandwiched in between steel thrust plates interposed between the axle housing and the babbit ring on one side and the differential case and the babbit ring on its other side. The function of the radius rods which extend from the ends of the axle shaft housing to the flanged fitting back of the ball joint is to strengthen the entire rear axle construction as they form a triangle having the apex at the universal joint end. Any tendency of either end of the axle housing to move backwards or forwards or for the housing enclosing the driving shaft to twist or bend is corrected by these rods.

Purpose of Differential Gear.—One of the most important yet inconspicuous elements of any form of automobile driving system is the differential gear, but as this is usually placed at a point where it is not easily seen by the motorist and as but very little trouble is experienced from this mechanism, many owners of cars are not aware of its existence and do not realize the important work performed by this relatively simple component. Without a differential gear it would be difficult to control the machine when driving around corners, so this really per-

forms an important function with both steering and driving systems.

When turning corners with any four-wheel vehicle the outer wheels must turn at a higher rate of speed than the inner ones because they are describing a larger arc of the circle. The more sharply the vehicle is turned the greater the difference in velocity between the inner and outer wheels. In a horse-drawn conveyance all the wheels are independent of each other and may all revolve at different speeds if necessary, without interfering with each other or impairing the action of the conveyance. In an automobile different conditions prevail because while the front wheels are usually independent of each other, the driving wheels must be connected together so that each will receive its share of the energy produced by the motor and will perform its quota of the work incidental to propelling the vehicle.

In order to permit one of the driving wheels to turn at a lower speed than its mate in rounding a corner the balance or differential gear is used. Its simplest application is shown at Fig. 33. From this it is patent that the driving axle is split in the center and that the wheels are mounted on and driven by distinct axle shafts. (See Fig. 30.) At the inner end of each shaft a bevel gear is carried, these being firmly secured to the axles so they revolve with them. The main bevel-driven gear, which is actuated by the driving pinion turned by the engine, is mounted independent of the axles and is coupled to them by means of small bevel pinions which are applied so that they will drive the gears on the axle shafts. Assuming that all the gears are in mesh, as outlined, and that power is being applied to the driven gear, and that the resistance to traction is the same at both rear wheels, the entire as-

sembly comprised of driven gear, the differential pinions attached to it and the axle shafts revolve as a unit.

If the resistance against the driving wheels varies so one wheel tends to revolve faster than the other, the differential pinions will not only turn around on the studs on which they are mounted, but at the same time will run

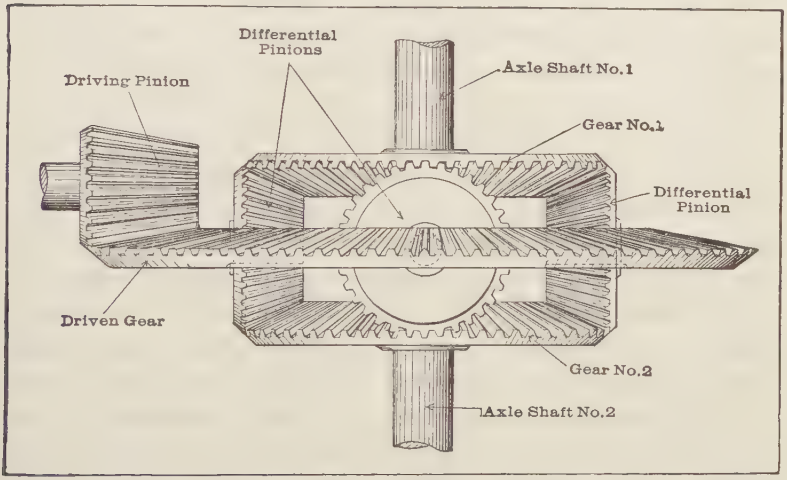

Fig. 33.—Simplified Diagram to Accompany Explanation of Differential Gear Action.

around the gears on the axle shafts, because the bevel driven gear carrying the studs on which the differential pinions revolve moves forward. When turning a corner the outer wheel must turn so much faster than the inner member that it is just the same as though one of the wheels was held stationary and the other turned. If both wheels are turning forward at the same speed, the differential pinions remain stationary and act simply as a lock which forms a driving connection between gear No. 1 on axle shaft No. 1 and gear No. 2 on axle shaft No. 2. This will mean that

both wheels must turn in the same direction as long as the work is uniformly distributed. Just as soon as the resistances are unequal the differential pinions will turn on their supporting studs and one member may turn at comparatively slow speed while the other revolves at a much faster rate. The action of the differential pinions may be clearly understood by reference to Fig. 33 and giving due consideration to the following principles. The same resistance at the point of contact between the driving wheels and the ground prevents the pinions from revolving on their own studs, and in this case they are carried around by the supporting members and the ring gear. If the resistance upon axle shaft No. 1 is greater than that on axle shaft No. 2, the ring gear will rotate forward with the wheel offering the least resistance and the differential pinions will turn on their studs and run over the surface of the gear which tends to remain stationary, this being the one against which there is the greatest resistance. The differential pinions can thus turn independently of one gear wheel and run over its surface without turning it, and at the same time act as a clutching member of sufficient capacity on the other gear and axle to carry them in the same direction as the ring gear and at a ratio of speed which will depend upon the difference in resistance between the driving members and the ground.

Utility of Motor-Car Brakes.—One of the most important of the components of the motor-car controlling system is usually carried with and forms part of the rear construction, this being the braking means which is utilized to bring the vehicle to a stop when it is desired to arrest forward or backward motion. It will be evident that in a horse-drawn vehicle the animal drawing it can be used as brake, but that in any form of self-propelling convey-

ance it is essential that some means of stopping be included in the construction. Even if the clutch was operated in such a way that the motor was disconnected from the driving wheels the conveyance would continue to move because it had acquired a certain momentum which would increase in value with the weight of the car and the speed at which it was driven.

There are three brakes provided on the Ford chassis, one of these being a service brake acting on the transmission gear, the other two being emergency members acting on the drums carried by the rear wheels. The service or transmission brake is clearly shown in the view at the top of Fig. 28 in connection with its operating pedal and is also outlined at the bottom of the same illustration which shows the gearing when the top portion of the gear case is removed to expose the three transmission bands. The transmission brake is the one normally used when driving the car and is operated by the right hand pedal of the control assembly which is marked B. When the pedal is pushed forward it constricts an asbestos fabric lined brake band around the drum that also forms the casing for the multiple disk clutch assembly. As this drum is part of the assembly to which the propeller shaft is attached and as this in turn controls the rear wheels through the medium of the bevel pinion carried at its lower end, whenever the transmission assembly is gripped by this brake band it will also retard the movement of the rear wheels and if the brake pedal is pushed tightly enough the friction will be so great that the rear wheels cannot turn and must come to rest even on a steep incline. This is called the "service brake" because it is more generally used than the hand operated or emergency brake acting directly on the rear wheel drums.

The emergency brakes are of the type shown at Fig. 34. These consist of a pair of semicircular cast iron shoe members held together against an anchorage pin and an expanding cam by coil springs as shown. The diameter of the circle formed by these two metal shoes is slightly less than the inside diameter of the brake drum when the

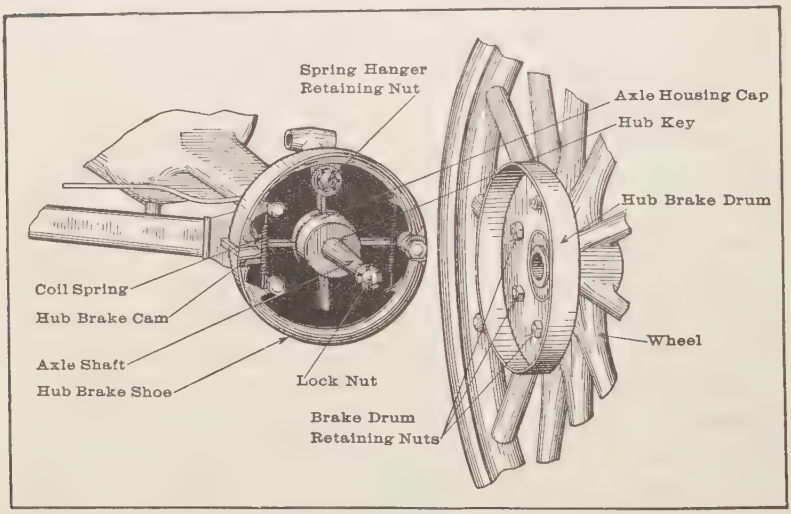

Fig. 34.—End View of Ford Rear Axle with Wheel Removed to Show Emergency Brake Construction.

brake is not in use. If the hub brake cam is rocked, however, so that instead of lying flat it is moved at such an angle that the brake shoes are spread apart they will grip the internal periphery of the pressed steel brake drum, retarding or entirely stopping the movement of the wheels, depending upon the pressure applied at the end of the hand lever and the movement of the actuating cam. As soon as the pressure is released the coil springs bring

the brake shoes out of contact with the drum and permit free rotation of the wheel.

The brake actuating cams are controlled by small levers which are connected with smaller members on the ends of the control shaft which is worked by the hand lever. Rods are utilized to join these levers, these being guided by clips secured to the radius rods. When the hand lever is pulled toward the operator or the rear of the machine it moves the controller shaft and rods forward and pulls the cam operating levers so these spread the brake shoes apart. The emergency brake linkage is interconnected with the clutch actuating pedal so when the handle is placed in a certain position the clutch will be disengaged but the brakes will not be brought into action until a further movement of the hand lever takes place. The handle may be locked in any desired position by a simple ratchet and pawl arrangement at its lower end. This is a good feature as the emergency brakes may be applied to prevent the car from moving when the motor is being cranked or when it is left unattended on a grade. The service brake may be operated at the same time as the emergency brakes are, if desired, though it is only on very steep hills that both brakes can be used to advantage.

The Ford Steering Gear.—The manner in which the front wheels are carried by movable steering spindle members has been clearly described in the first chapter, as was the linkage by which the two steering knuckles are caused to move simultaneously when the drag link connecting the front axle with the steering gear is moved by the hand wheel. It was explained that the steering arm at the lower portion of the steering gear was moved by the hand wheel carried at the top of the steering column and shown at Fig. 35, A. The steering post is a metal

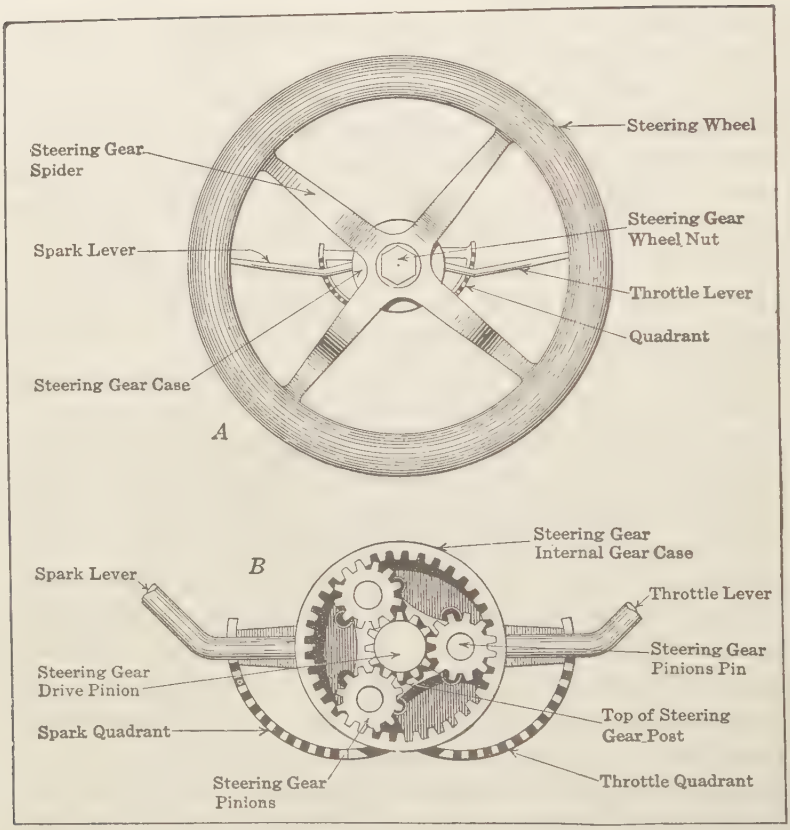

Fig. 35.—Top View of the Ford Steering Gear at A Showing Steering Wheel and Motor Speed Controlling Levers. Planetary Reduction Gearing is Depicted at B which Shows Gear Compartment with Cover Removed.

rod carried inside of the column which is capable of being moved a certain number of degrees to rock the steering arm, this being limited by the travel of the front wheels. The steering column is attached to the dash and is set at such an angle that the hand wheel is brought in a con-

venient position for the operator. The steering post is housed in a metal tube having an inside diameter sufficiently large to permit of free rotation of the steering post and also to carry the spark and throttle actuating rods which are worked by levers placed below the steering wheel in a position convenient for the operator. The steering wheel consists of a metal spider having four arms which terminate at the oval section rim which is of wood. These arms converge to a boss which forms the center of the steering wheel, a hole being machined in this boss so that the wheel is a tight fit on the member to which it is attached by key and retention nut.

The Ford steering gear differs radically from the conventional forms and is a patented design. The reduction gears which permit of a greater degree of hand wheel movement than of the steering arm are located at the top of the steering column instead of at the bottom as in most other cars. Whereas the worm gear reduction is popular on other types the Ford gearing operates on the epicyclic or planetary principle. The gearing is carried in a compartment immediately under the steering wheel which has a removable cover to permit of examining the gears which require but little attention other than keeping the compartment filled with grease. The construction of this gearing is clearly shown at Fig. 35, B. Four gears of the external spur form are used, one of these being in the center while three surround this member, being carried by studs secured to a triangular plate at the top of the steering post. The casing is provided with teeth on its inner periphery so that it is an internal spur gear. The three outer gears are in mesh with this as well as the central member to which the steering wheel is attached. When the wheel is rotated it turns the center

pinion which causes the other three pinions attached to a steering column to rotate also. When the steering wheel is turned to the right the three outer gears are turned in the opposite direction but they are restrained by the internal gear case in such a way that the top of the steering post to which they are fastened moves in the same direction as the hand wheel but travels slower. This provides a certain amount of leverage which makes it easy for the operator to steer the car even under unfavorable road conditions. The spark and throttle levers may be set at any desired position because they work on fixed quadrants attached to the steering column. The spark and throttle control levers do not turn with the steering wheel.

Construction of Ford Tires.—The most common form of tire, and that used on Ford automobiles, is composed of a hollow endless rubber ring or tube of circular section filled with air and protected from wear by means of an outer shoe or casing. The use of air under compression provides a very resilient medium for supporting the vehicle, and of the various forms of rubber tires the pneumatic form is the one that is the most desirable for pleasure cars. The development of the modern automobile may be attributed largely to the advances made in pneumatic-tire construction, as these members made it possible to drive automobiles at high speeds over rough road surfaces without stressing the mechanism unduly or causing discomfort to the passengers. The Ford front tires are 30″ x 3″, the rear ones 30″ x 3½″. These are economical as they are easy to buy and give excellent mileage if the car is driven carefully.

The pneumatic tire of the present day is invariably of the double-tube type and is composed of two members, the inner tube and the shoe or carcass. The inner member is

utilized to retain the air and is made of a very pure rubber or resilient rubber composition with walls about an eighth of an inch thick for cars of average weight.

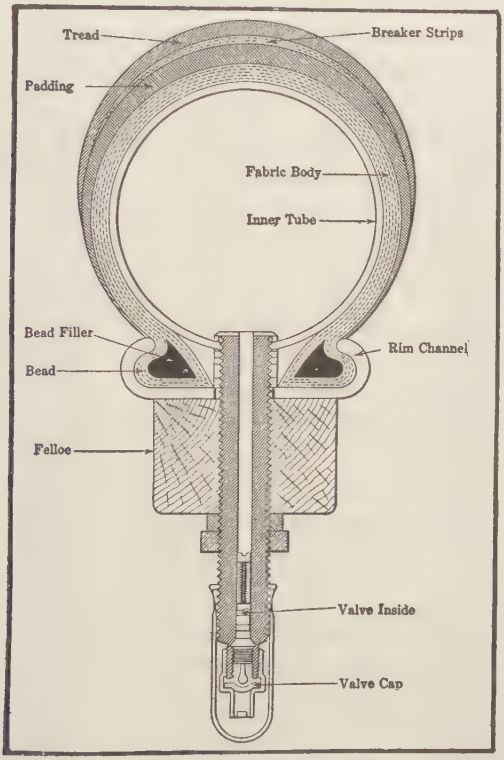

Fig. 36.—Sectional View of Standard Clincher Double Tube Pneumatic Tire Such as Used on Ford Cars.

While this tube is very elastic and is airtight, it would not be strong enough or have adequate resistance to be run directly in contact with the road surface; therefore it is necessary to protect it by a shoe composed of layers of fabric and rubber composition. The shoe member is pro-

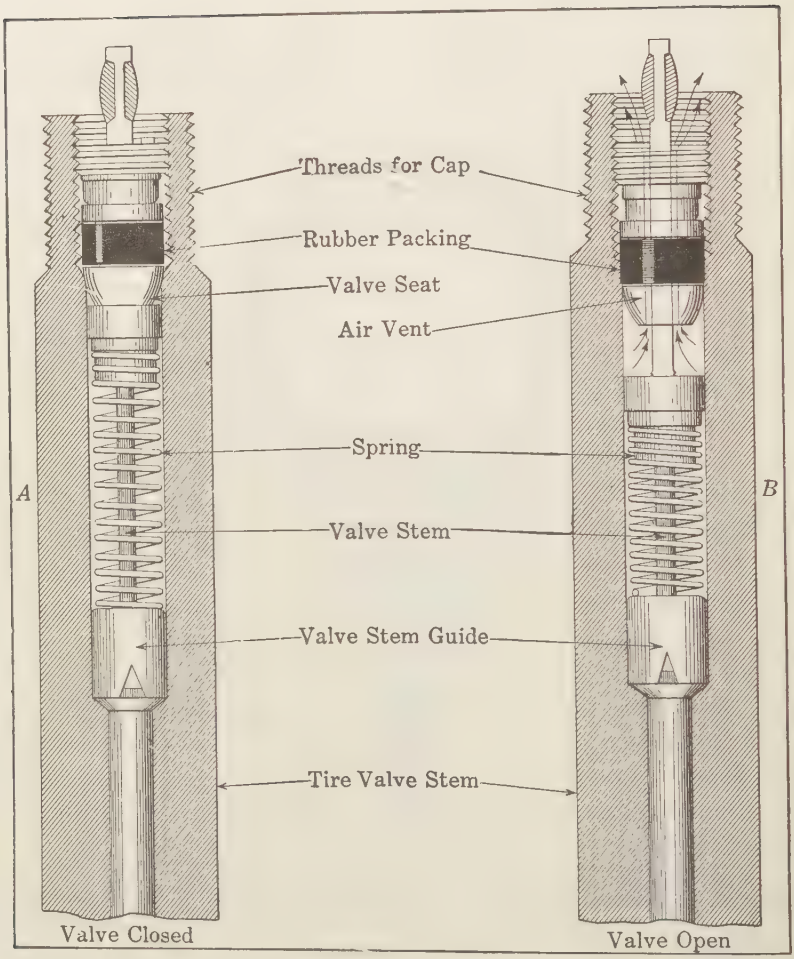

Fig. 37.—Sectional View Showing Construction of Standard Schrader Universal Check Valve For Introducing Air to Pneumatic Tire Inner Tubes. This is Utilized In Practically All Tires of American Manufacture.

vided with beads on its inner periphery designed to interlock with the rim channel, as shown on Fig. 36. The main portion of the outer casing is composed of five or more layers of a Sea Island cotton fabric "frictioned" with high-grade rubber composition. This is forced into the mesh of the cloth by machinery so the fabric will be practically waterproof and will join intimately with other plies by a process of vulcanization when the shoe is cured after it is built up. Outside of the fabric body a layer of a very resilient rubber, approximately of crescent form, known as the padding, is provided to give a certain degree of elasticity. On top of this strips of heavy fabric called the "breaker strip" are interposed to offer a certain degree of resistance to any sharp object that might penetrate the tread and go through the padding and into the fabric body if the breaker strips were not interposed to deflect the puncturing object to one side.

The tread is the part of the tire that is subjected to the greatest stress as it must resist the abrading influence of the road and when the tire is used on the rear wheels, the wearing effect of the friction produced by the tractive effort which exists at the point of contact between the driving member and the ground. The tread is of very tough rubber composition and differs from the material used as padding or for the inner tube in that it does not possess a very great degree of elasticity. This quality is sacrificed for that of greater strength and resistance to wear, which is more essential at this point.

The air is introduced in the tire through a simple form of automatic valve which is securely attached to the inner tube. As the inner tube becomes distended by the air pumped into it, it forces the beads of the tire outward and clinches the shoe so firmly in the rim channel that it will

be impossible to dislodge it without the use of special tire irons, and then only when the air pressure is relieved from the inner tube. A detailed view of the valve stem in the open and closed positions is shown at Fig. 37 and the construction of this simple fitting can be easily understood. The valve is held against its seat by a tension spring and will only open when the valve stem is depressed by the hand or from the pressure of the air forced against it from a pump when it is desired to inflate the tire. While the air pressure from the pump will be sufficient to force the valve from its seat, the air pressure from the inside of the tire only serves to hold it more firmly in place. Complete instructions for the manipulation, care and repair of Ford tires is given in the next chapter.

Ford Now Uses Balloon Tires.—The latest model Ford cars can now be obtained with demountable rims carrying low-pressure or balloon tires. These tires are of the cord construction instead of the fabric type so widely used in the past. Owing to the use of the cords for the outer casing, fewer plies may be used and the walls are more flexible. The tires are larger in sectional diameter than the high pressure tires, the latter were 3½ inches rear and 3 inches front prior to fitting demountable rims, then the same size (30x3½) was used all around inflated to 50 or 60 pounds air pressure. The balloon cords for Ford cars are 4.40 inches and are inflated at from 30 to 35 pounds air pressure. Not only the riding qualities are improved, but also the appearance as can be ascertained by referring to illustrations of new type cars at Figs. 170, 171 and 172.

CHAPTER IV

DRIVING AND MAINTENANCE OF FORD CARS

Steps Before Starting the Engine—How to Start the Ford Motor—Controlling Ford Cars—General Driving Instructions—Suggestions for Oiling—Winter Care of Automobiles—The Ford Gas Lighting System—Electric Lighting for Ford Cars—Tools and Supplies for Pneumatic Tire Repair—Tire Manipulation Hints—Tire Repair and Maintenance—Tools for Ford Cars—A Typical Engine Stop Analyzed—Conditions That Cause Failure of the Ignition System—Common Defects in Fuel Systems—Faults in Oiling and Cooling Systems—Adjusting Transmission—Adjusting Loose Front Wheels—What to Do When Rear Brakes Do Not Hold.

THERE is no point in connection with automobiles that should be covered more completely than that of general operation and maintenance. Even if the motorist does not intend to repair his own car he should be able to care for it intelligently and to locate the various troubles that are apt to materialize while the car is in operation. An engine stop on a lonely road will be a serious matter to one who does not understand the principles of action of the power plant, but only an incident to one who does. If the general principles are understood and the methods of locating ordinary troubles are kept in mind the motorist will be able to keep the car in operation and will fix many of the minor derangements which otherwise would need attention from the repairman, who might not be available when most needed. In presenting this chapter on driving and maintenance the writer wishes to emphasize that endeavor has been made to group practically all

the information which the operator of the Ford car must have in order to drive intelligently in one chapter. Included with general operating instructions will be found suggestions for systematic location of power plant defects which should be of value to the novice.

Steps Before Starting the Engine.—Before attempting to start the motor there are a number of preliminary precautions to be taken in order to make sure that the car is ready for the road. The gasoline container of the Ford automobile has a capacity of ten gallons, and this should

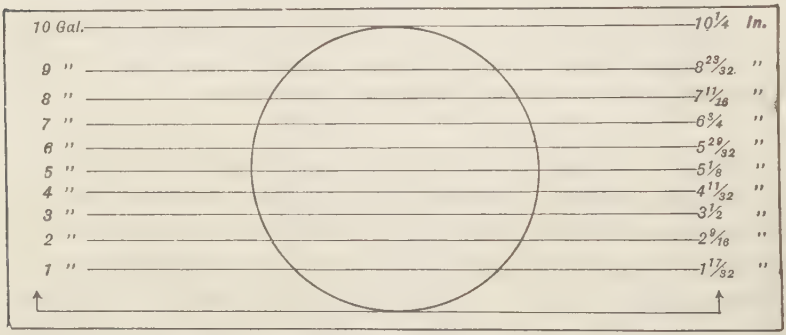

Fig. 39.—Diagram Showing Method of Marking Measuring Stick to Indicate Contents of Ford Ten Gallon Tank.

be filled practically to the top, and care should be taken never to start out with less than half a tank full. In order to determine the amount of fuel available a measuring stick may be made according to the dimensions given at Fig. 39, which can be introduced into the top of filler opening to gauge the supply of liquid in the container. The mark to indicate 1 gallon should be made $1\frac{17}{32}$" from the lower end of the stick. The mark to indicate 2 gallons should be made $2\frac{9}{16}$" from the bottom and so on according to the figures given in the diagram. In order to have the

liquid show it may be well to paint the stick with a black enamel before marking it. When filling a gasoline tank it is important to use a strainer to prevent water and other foreign substances from reaching the tank interior. Chamois skin is an excellent strainer for gasoline. Three or four layers of fine mesh cotton cloth may also be placed across the mouth of the funnel if the chamois is not available.

As gasoline vapor is explosive it is well to make sure that there are no naked flames within several feet of the tank. When filling the tank at night be sure that the oil side lights are extinguished before any fuel is poured. It is important that no matches should be lighted anywhere near where gasoline has been spilled as the air for several feet surrounding the spot has become saturated with highly explosive vapor. The small vent holes in the fuel tank cap should always be free, as if this is plugged up it will prevent the gasoline from flowing into the carburetor, as the fuel would become air-bound in the tank. As has been previously explained, any dirt or foreign matter that would pass into the carburetor will usually fall to the bottom of the sediment bulb on the bottom of the tank, from which it may be drained out by opening a petcock screwed into the bottom of the sediment bulb casting. A shut-off valve is also provided so the gasoline supply in the tank may be conserved at such times as is necessary to remove the feed pipe running to the carburetor. After being sure that the gasoline tank is full the next step is to ascertain that the shut-off valve is opened so that the liquid can flow to the vaporizer.

Before starting out always make sure that a proper supply of medium body, high grade gas engine cylinder oil is poured into the crank case through the breather pipe

at the front of the engine. This is clearly shown in the various views of the engine in other chapters and in Fig. 45 herewith. This opening is covered by a brass cap which may be easily withdrawn as it is held in place only by frictional contact. In the back of the lower part of the flywheel casing, which is also the reservoir that holds the oil, are found two petcocks. Be sure the car is on a level floor and pour in oil slowly until it runs out of the upper petcock. Have a can so that the oil running out will be saved. Leave this petcock or small faucet open until the oil stops running, then close it. After the car has been used long enough for the engine to become thoroughly free and easy running, which indicates that all parts have attained the proper bearing, the best results will be obtained by carrying the oil at a level about midway between the two petcocks. If the lower petcock is opened and no oil comes out a proper supply should be immediately placed in the crank case.

Having made sure that there is a proper supply of fuel and lubricating oil the next step is to insure that the cooling supply is adequate. Remove the cap at the top of the radiator and fill with clean, fresh water. If water is taken from a stream or from any other source where there is any question of its cleanliness it is advisable to strain it through muslin or other similar material to keep dirt from getting in and constricting the small bore of the radiator tubes. The Ford cooling system has a capacity for slightly more than three gallons of water. Never run the engine unless the radiator has been filled. The water should be poured in until it runs out of the overflow pipe to the ground which may be accepted as an indication that both radiator and the cylinder water jacket have received an adequate supply. When starting out with a new car or

after the engine has been overhauled and parts refitted it is good practice to examine the radiator frequently and to make sure that it is kept properly filled. If the car is used for long distances on slow speed, such as hill climbing and pulling through sand the engine may heat up sufficiently as to boil out the water so that great care should be taken when operating a car under these conditions to replenish the water supply as often as may be necessary. If the only water available contains alkalies and other salts which will deposit sediment in the radiator and water jackets attempt should be made to secure clean soft water such as rain water.

How to Start the Ford Motor.—The essential precautions enumerated having been taken, the first step in starting the motor is to look at the steering wheel and notice the position of the spark and throttle control levers which are clearly shown in inset, Fig. 42. The right hand lever is called a "throttle," as it controls the amount of gaseous mixture drawn into the motor. When the power plant is in operation the nearer the operator this lever is the faster the engine will turn and the greater the power output. The left hand lever controls the spark which should be in retard position or at its extreme position away from the operator when starting the motor. It is possible in many cases to advance this lever three or four notches by moving it toward the seat without any danger of injury in cranking. The throttle lever should be placed about four or five notches down to secure easy starting. The reason it is desirable not to advance the spark control lever too far is that the engine may kick back. This may result in damage to the wrist or arm of the person cranking the motor unless care is taken in the method of handling the starting crank. Before cranking

the engine one should make sure that the emergency brake lever is pulled back as far as it will go. When in this position the clutch is out and the hub brakes are engaged, which prevents the car from moving. After inserting the switch

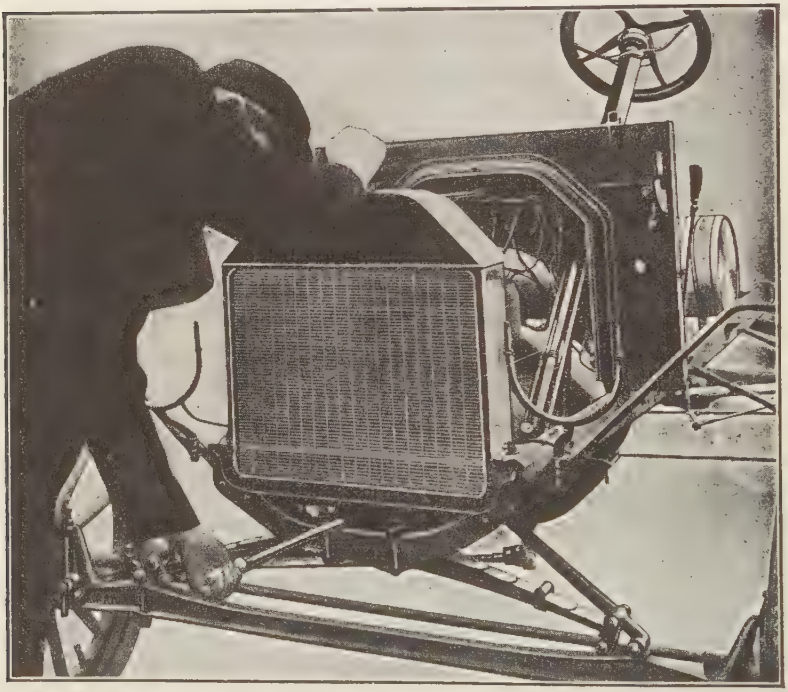

Fig. 40.—Illustrating Correct Method of Grasping Starting Crank to Avoid Injury Due to Back Kick.

key in the switch on the coil box, throw the switch lever as far to the left as it will go toward the point marked "magneto." The engine cannot be started until the electrical circuit is complete. If batteries are used for ignition as an auxiliary it may be possible to start the engine easier on the battery current, though a very easy start may

be secured on the magneto provided the coil vibrators are properly adjusted.

After having put the switch in either battery or magneto position the next step is to crank the engine by lifting on the starting crank at the front of the car. Take hold of the handle and push the crank in toward the car until you feel the ratchet on the crank engage with the pin passing through the crank shaft. The crank handle should be pulled upward with a quick swing. The proper method of grasping a crank is shown at Fig. 40. It will be observed that the crank is grasped in the left hand and that any tendency to backfire will pull the handle out of the hand by opening the fingers. The improper method of cranking is shown at Fig. 41. In this case the right hand is placed around the crank handle and the engine is started by pushing down against the compression instead of lifting up on the handle to overcome the compression resistance. It will be evident that if the spark advance lever is set so that an early explosion obtains this will drive the handle vigorously backward, which force is partially resisted by the tensed arm of the operator. There are times when it is necessary to turn the crank vigorously which is called "spinning" the engine. In this case be sure that the spark lever is fully retarded, otherwise a sudden backfire may cause injury.

If the engine has been standing for a time it is advisable to prime the carburetor by pulling on the small wire at the lower left corner of the radiator while giving the engine two or three quarter turns with the starting handle. In this case the crank should be grasped by the right hand but care should be taken to only pull up against the compression. In cold weather gasoline does not evaporate very readily so it is somewhat more difficult to start

a motor under these conditions. The method recommended by the Ford company for starting the engine when cold is to turn the carburetor dash adjustment one quarter turn to the left in order to allow a richer mixture of gasoline to be drawn into the cylinders, then to hold out

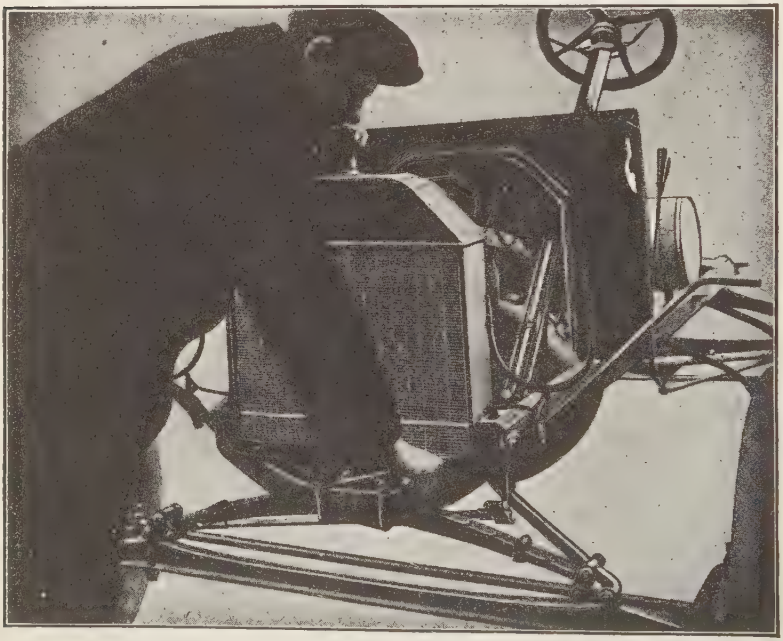

Fig. 41.—Showing Wrong Method of Exerting Pressure on Crank When Starting Motor.

the priming rod which projects through the radiator while the crank is whirled vigorously. Another method is as follows: Before throwing on the magneto switch close the throttle lever, hold out priming rod while you give crank several quick turns, then let go of priming rod, place the spark lever in third or fourth notch, advance

throttle lever several notches, throw on the switch and crank briskly.

After starting the motor it is advisable to advance the spark half way down the quadrant and to let the motor run until thoroughly heated up. If one starts out with a cold motor it is not likely to have much power and it would be easy to "stall" it. It is said that the advantage of turning on the switch last after priming is that there is plenty of gas in the cylinders to keep the motor running. After the motor is warmed up the carburetor adjustment should be turned back to the proper running position. If, for any reason, the engine is warm and does not start readily it is probably because the engine has been flooded with an over rich gas mixture. The remedy for this condition is to turn the carburetor adjusting needle down by screwing the needle valve on the dash to the right until the needle seats in the carburetor. Crank the engine briskly to exhaust the rich gas, then throw on the switch and start the engine. As soon as the cylinders fire turn back the needle to the normal running position.

If the engine fails to start the following defective conditions may be responsible: Water in the gasoline; water or hardened oil in commutator; coil vibrators out of proper adjustment; gas mixture too thin; gas mixture too rich; magneto contact point in transmission cover raised because of foreign matter or short circuiting by a piece of wire from brake lining; gasoline supply shut off; water frozen in gasoline tank sediment bulb; poor contact at coil switch; loose magneto wire leading to coil; loose timer wires; engine too cold to properly vaporize gas (only in zero weather). Should the engine start, run for a time and then stop suddenly, one should make sure that there is plenty of fuel in the gasoline tank. The trouble

may be a flooded carburetor; dirt in carburetor or feed pipe; magneto wire loose at either terminal; magneto current collecting point obstructed; engine overheated on account of insufficient oil or water supply.

If the engine lacks power and runs irregularly, which is called "skipping" at low speed it may be due to: imperfect gas mixture; dirty spark plugs; poorly adjusted coil vibrators; poor compression; air leak through intake manifold; weak exhaust valve springs, too little clearance between valve stem and operating push rod; spark plug points too near together.

If the engine misfires at high speed, it may result from imperfect contact in the interior of the commutator; too much air gap between the points of the spark plugs; imperfect gas mixture or poorly adjusted vibrators. When an engine overheats, the most common condition is running with too rich gas mixture and retarded spark. Other troubles are: insufficient lubricating oil; not enough water in the radiator; fan belt too loose or slipping; water circulation poor, owing to sediment in radiator tubes; or carbon deposits in combustion chambers. These carbon deposits may be also present on the piston head and will result in loss of power as well as produce knocking sounds. If a loud knock is evident it is usually due to a loose connecting rod or crank shaft bearing or running with the spark advanced too far and it is always the sign of a badly overheated engine.

Controlling the Ford Car.—The Ford car is one of the most popular of moderate-priced automobiles and over 600,000 of the Model "T" are now on the road. The control system of this car is extremely simple and yet it is different from that of any other automobile. The gearset, which has been previously described, is a plane-

tary type which gives two forward speeds and a reverse motion. The conventional form of steering wheel is used to control the direction of car travel, and spark and throttle levers are mounted on steering column beneath the wheel to control the speed of the power plant. It is in

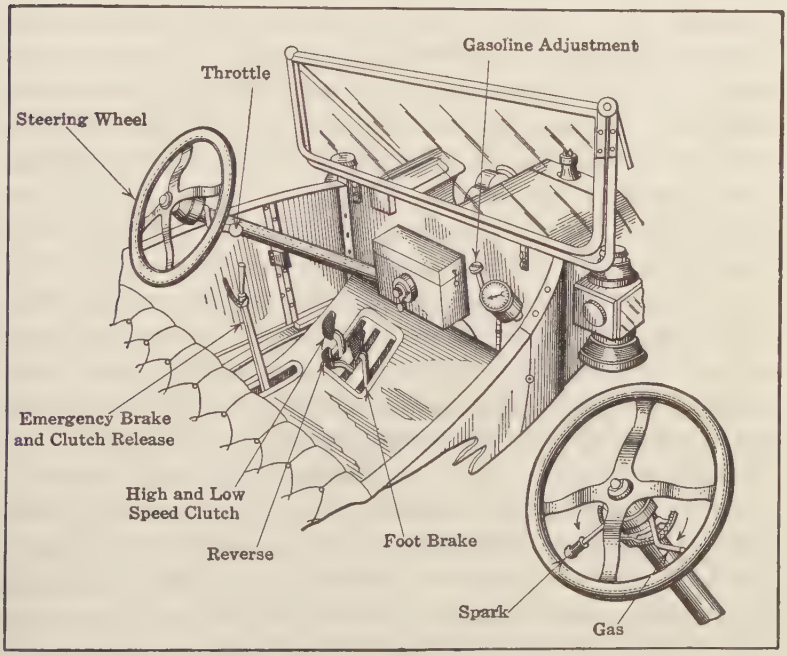

Fig. 42.—The Control System of the Ford Model T Car.

the method of obtaining the various speed ratios that the control system is distinctive. As will be seen by referring to Fig. 42, three pedals and a hand lever are provided on the left side of the car. The pedal on the extreme left side controls the high and low-speed clutches and is marked "C." That next to it, which is marked "R," is

used to constrict the reverse band of the transmission and obtain reverse motion. The pedal at the right, which is provided with a letter "B" cast on its surface, is used to apply the foot brake.

The hand lever engages the high speed or direct drive clutch when thrown forward and when pulled back it actuates the emergency brake which cannot be applied without releasing the direct drive clutch. The lever may be set in a neutral position and the clutch will be released without applying the brake when it is approximately vertical. When the high speed is in and the hand lever is thrown way forward the high speed clutch may be released by a light pressure on pedal "C" and a further movement of this pedal will apply the low speed. Thus one pedal gives control of both high and low speeds forward and the clutch can be released in exactly the same manner as that of a sliding gear driven car when it is desired to slow up such as for turning a corner, descending a hill or passing another vehicle.

Before starting the car the hand lever must be in a vertical position, this releasing the clutch and applying the emergency brakes. To start the car, after the engine has been started, the foot is placed on the clutch pedal to keep it in a neutral position while the hand lever is thrown as far forward as it will go. The engine is then accelerated and the clutch pedal is pushed forward until the slow speed band tightens around the drum of the transmission and the car gathers headway on the lower ratio. After it has attained a certain momentum the clutch pedal is allowed to drop back gradually into the high-speed position. The foot may then be removed until such times that the clutch must be disconnected. Before applying the foot brake, which is done by pressing with the right

foot upon the pedal marked "B," the clutch pedal should be put in neutral position with the left foot.

To reverse the car, it must first be brought to a standstill. The engine is kept running and the clutch is disengaged with the hand lever, which is placed in the neutral position but not pulled far enough back to apply the emergency brake. The reverse pedal marked "R" is then pushed forward with the left foot leaving the right one free to use on the brake pedal if needed. To stop the car, the throttle is closed so the engine will not race; the high speed is released by pressing the clutch pedal forward into its neutral position and applying the foot brake slowly, but firmly, until the forward motion of the car is arrested. It is imperative that the foot be retained on the clutch pedal until the hand lever is pulled back to its neutral position. The placing of the spark and throttle levers is clearly shown in the inset in the right-hand corner of the cut, both levers being pulled back to accelerate the motor and pushed forward to slow it down.

General Driving Instructions.—The following instructions apply to all types of gasoline automobiles as much as to the Ford and may be followed to advantage by all motorists. The gear-shift lever should always be placed in a neutral position when the car is stopped, whether it is left alone or attended. The clutch should always be applied gradually and as slowly as possible because too sudden or harsh engagement will produce stresses that will injure the tires or driving mechanism of the chassis. Never allow the engine to race or run excessively fast when changing speeds, and it is well not to undertake to change speeds with either motor or car running at high speed. When changing down, i. e., from a higher to a lower gear, allow the car to slow down until its speed is

about the same as that which will be produced by the lower gear ratio desired before the clutch is engaged to produce the lower speed.

Always drive a car slowly and cautiously until you are thoroughly familiar with the control mechanism and the methods of stopping the car. When driving up grades on the high speed, if the motor shows any tendency to labor, shift back into the lower gear ratio which has been provided for that purpose. Many motorists believe that the best test of a car's ability is to rush all hills or bad spots in the roads on the direct drive. It should be remembered, that the lower speed ratio was provided for use at all times when employing the high speed might produce injurious stresses in the motor. All unusual noises should be investigated at once as these sounds usually presage more or less serious trouble. A gasoline car should never be driven with a slipping clutch, and it is imperative that the brakes and steering gear be frequently inspected to make sure that they are in proper order.

One should never attempt to drive Ford cars at high speeds unless the tire casings are in perfect condition and the road surfaces good. When driving on clay or muddy roads, or on wet asphalt, care must be taken in turning corners and the car should be driven cautiously to avoid dangerous side slipping or skidding. When driving on unfavorable highway surfaces always keep one side of the car on firm ground, if possible. Brakes should always be carefully applied, especially if the road surfaces are wet. An automobile should never be brought to a stop in mud, clay or sand, snow or slush, if it can be avoided. Whenever road conditions are unfavorable the smooth tread tires of the driving wheels should always be fitted

Fig. 43.—Showing Method of Applying Non-Skid Chain to Driving Wheels to Insure Adequate Traction on Wet or Slippery Roads.

with chain-tire grips, as shown at Fig. 43, to insure having adequate traction.

All motorists should familiarize themselves as much as possible with the mechanism of their cars and should feel competent enough to make the ordinary adjustments and minor repairs before any long trips are attempted. A full equipment of tools and spare tires and casings should be carried at all times. It is well to remember that the manufacturer of the car has issued a set of instructions for its care and maintenance, and these should be followed as closely as possible because intelligent care of any piece of machinery means long life and reliable service and the automobile is no exception to the rule.

Suggestions for Oiling.—One of the most important points to be observed in connection with gasoline automobile operation is that all parts be oiled regularly. It is not enough to apply lubricant indiscriminately to the various chassis parts, but it must be done systematically and logically to secure the best results and insure economical use of lubricant. The most important parts are the power plant and transmission system and the engine is but one point in the car that must be properly oiled at all times to obtain satisfactory results. Some of the running-gear parts are relatively unimportant, others demand regular inspection and oiling. A very comprehensive oiling chart is presented at Fig. 44, this showing practically all of the points that require oil as well as giving instructions regarding the character of the lubricant needed and how often it should be applied. Some of the points are governed by special instructions, these being the transmission case, timer, and rear axle. Use only the best medium body cylinder oil in the Ford motor. The writer has obtained excellent results by putting in a quart

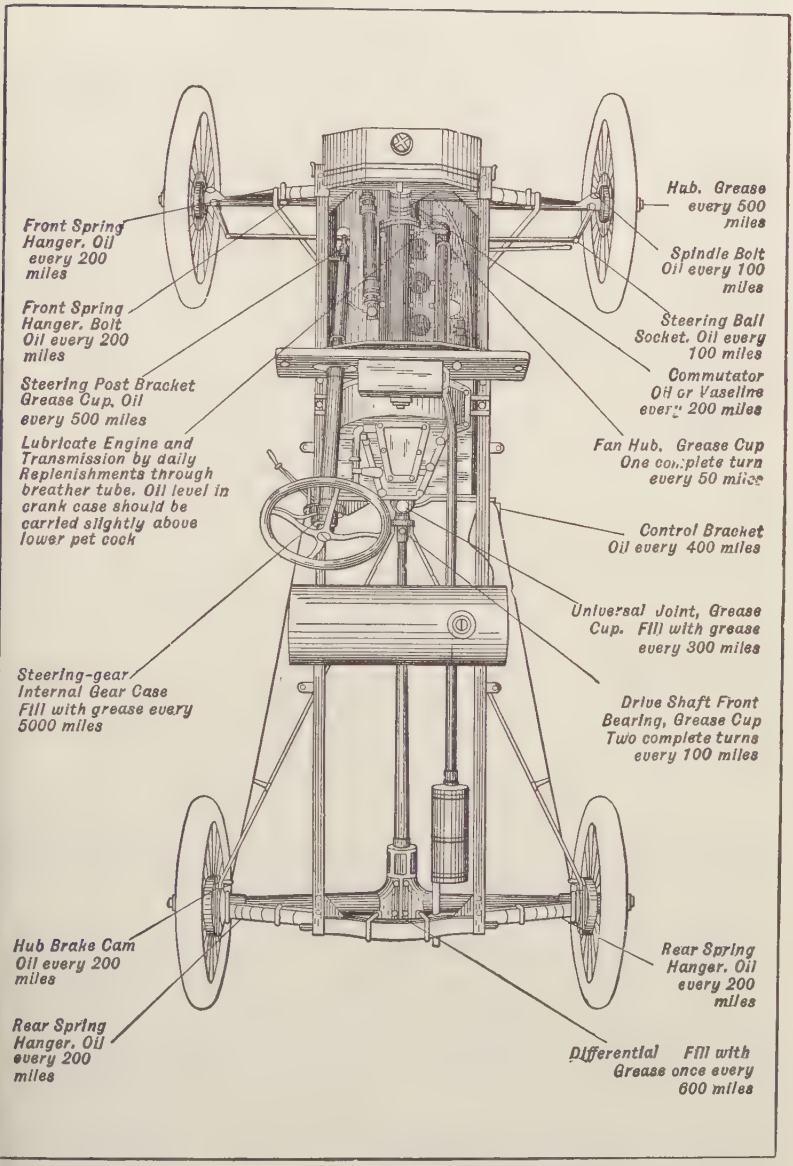
Front Spring Hanger. Oil every 200 miles
Front Spring Hanger. Bolt Oil every 200 miles
Steering Post Bracket Grease Cup. Oil every 500 miles
Lubricate Engine and Transmission by daily Replenishments through breather tube. Oil level in crank case should be carried slightly above lower pet cock
Steering-gear Internal Gear Case Fill with grease every 5000 miles
Hub Brake Cam Oil every 200 miles
Rear Spring Hanger. Oil every 200 miles
Hub. Grease every 500 miles
Spindle Bolt Oil every 100 miles
Steering Ball Socket. Oil every 100 miles
Commutator Oil or Vaseline every 200 miles
Fan Hub. Grease Cup One complete turn every 50 miles
Control Bracket Oil every 400 miles
Universal Joint, Grease Cup. Fill with grease every 300 miles
Drive Shaft Front Bearing, Grease Cup Two complete turns every 100 miles
Rear Spring Hanger. Oil every 200 miles
Differential Fill with Grease once every 600 miles

Fig. 44.—Plan View of Ford Model T Chassis Showing Important Points Requiring Lubrication and When This Attention is Needed.

of lubricant to every five gallons of gasoline, the oil was introduced through the breather pipe every time that amount of fuel was placed in the tank.

Neither the transmission case nor the differential case on the rear axle should be filled with heavy "Dope"

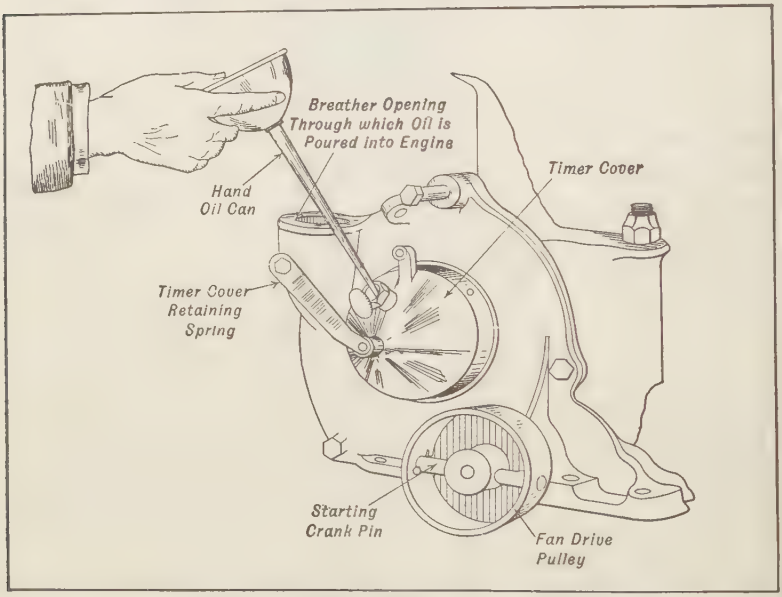

Fig. 45.—Method of Oiling the Ford Commutator or Timer With Light Oil. Note Breather Opening Back of Timer Through Which Oil is Poured Into Crank Case.

widely sold, which may contain fiber or cork particles to make for more silent operation. If gears are noisy it is either because they are worn or out of adjustment, and the use of the nostrums and freak lubricants will not improve their operation. The rear axle differential housing should be filled with as light mineral grease as it is possible to get, those having about the consistency of vaseline and containing graphite being most desirable as

lubricants. Light oils should not be used in the rear axle housing, because these will not stay in place but leak out over the brakes and will not have sufficient body to cushion the gear teeth. The only other point on the chart which needs explanation is lubrication of the timer interior. This should be oiled, as it is a roller contact form and a few drops of magneto or 3-in-1 oil should be applied to the roll and the contact segments once a week. The timer case should be removed and all old, dirty oil washed out with gasoline before fresh lubricant is supplied. Never use graphite grease or any heavy oil in a timer case because these will not only interfere with regular ignition by short circuiting the current, but they will clog up the timer and prevent the roller establishing proper contact with the segments. After a car is oiled it is well to go over all the exposed joints with a piece of cloth to remove the accumulation of surplus oil on the outside of the parts which serves no useful purpose and which only acts to attract and retain dust and grit. The instructions given on the chart can be followed to advantage on many types of gasoline cars, though, of course, the different constructions will have to be treated as the peculiarities of design dictate.

A systematic method of lubricating the various parts is much to be preferred to the usual haphazard way in which the cars are oiled. The speedometer may be used to check off the mileage made by the car and if a note is made of the distance covered no trouble should be experienced in following the chart at Fig. 44. The simplicity of the Ford car makes for easy lubrication as the entire mechanism can be thoroughly oiled in less than five minutes. The places needing lubrication, itemized under the heads of mileage covered, follow:

Lubricate After 200 Miles' Driving.

Lubricant	Number	Name of Parts
Oil	2	Front axle, steering knuckle pivots or spindle bolts.
Oil	2	Front spring shackles and bolts.
Oil	2	Yokes of tie rod.
Oil	1	Steering ball socket.
Oil	1	Commutator or timer.
Oil	2	Rear hub brake cams.
Oil	2	Rear spring shackles and bolts.
Turn grease cup	1	Fan hub.

Lubricate After 500 Miles' Driving.

Turn grease cup	1	Steering post bracket.
Turn grease cup	1	Universal joint of shaft.
Turn grease cup	1	Driving shaft front bearing.
Grease	2	Front wheel hubs.

Lubricate After 1,000 Miles' Driving.

Grease	1	Differential housing.

Lubricate After 2,000 Miles' Driving.

Oil	1	Control bracket.

Lubricate After 5,000 Miles' Driving.

Grease	1	Steering gear internal gear case.

Lubricate Daily.

Oil	1	Motor.

Lubricate Occasionally.

Oil	1	Fan belt shaft.
Oil	1	Fan belt pulley.
Oil	1	Crank handle bearing.
Oil	4	Yokes of brake rods.

In referring to the process of oiling, this means using a sufficient quantity to lubricate the bearing parts thoroughly, and turning the grease cups means that these assumedly contain grease. Greasing means packing the bearing or housing until it is filled. The caretaker can examine the condition of the grease cups, and when these are found properly filled they should be screwed down.

Filling and screwing down each cup three times, to insure ample supply of lubricant being in the bearing, is a safe practice to follow. The fourth time filled the cup can be left for the stated mileage interval. Care should be taken to wipe the cups clean before filling, to prevent dirt being carried into the bearings, and the oilers should be cleaned with equally good reason.

The best attention can be given at the end of the day's or night's driving, which will require but very little time, for conditions will all be favorable. The engine should be wiped clean while it is warm, for the oil or grease and dust accumulated will be soft enough to remove easily. The oil cups should be filled, all the grease cups turned according to the mileage for the day, the fuel supply renewed, the water supply in radiator replenished, and the oil in the engine case brought to the required level. The next time the machine is wanted it will be ready for use and the owner will know that it can be driven 200 miles or more with absolute certainty that it will have sufficient oil at all points except the engine which should be looked at at the end of 100 miles to make sure there is enough oil in the flywheel compartment.

Systematic attention to oiling and greasing, such as has been described, will so familiarize a man with the normal conditions that he will note whether or not there is wear of any of the moving parts, and one will find that there is usually need of tightening nuts and screws that will slacken, no matter how well they have been set, and these ought to be tightened. It is easy to discover loose parts while oiling and take immediate steps to remedy the defective condition.

Winter Care of Automobiles.—While motoring throughout the entire year is not unusual, many owners of cars,

especially in those portions of the country where the winter climate is exceptionally severe, put up their car for the winter period. If the car is kept in service the most important thing to do is to provide some good anti-freezing compound in order to prevent the water in the radiator and cylinders from congealing. There is some difference of opinion regarding the best solution to use to prevent cracked water jackets and burst radiators. Before we attempt to answer the questions often asked regarding the best anti-freezing compound, it will be well to consider the requirements of such compounds. To begin with it should have no deleterious effects on the metals or rubber used in the circulating system. It must be easily dissolved or combined with water, should be reasonably cheap, and not subject to waste by evaporation or be of such character that it will deposit foreign matter in the pipes. The boiling point should be higher than that of water to prevent boiling away of the solution at comparatively low temperature.

Solutions of calcium chloride have been very popular with motorists, and the writer will first discuss the use of this substance. The freezing point of the solution depends upon the proportion of the salt to the water. An important factor to be considered is that if the parts of the circulation system are composed of different metals there is liable to be a certain electrolytic action between the salt and the dissimilar metals at the points of juncture, a certain corrosion taking place, and the intensity of this corrosive effect is dependent upon the strength of the solution. As calcium chloride is derived from hydrochloric acid, which has very strong effect on metals, and as there may be particles of the free acid in the solution, a certain undesirable corrosive action may take place. In

using calcium chloride when compounding an anti-freezing solution care must be taken that commercially pure salt is employed, as the cruder grades will liberate a larger percentage of free acid. The mistake should not be made of using chloride of lime, which has much the same appearance, but the corrosive action of which is very great.

It is well to test a solution of calcium chloride for acid before placing it in the radiator. A piece of blue litmus paper may be obtained at any drug store and immersed in the solution. If the paper turns red it is a sign that there is acid present. Acid may be neutralized by the addition of a small quantity of slacked lime.

The solutions may be made in these proportions:

Two pounds of salt to the gallon of water will freeze at eighteen degrees Fahrenheit.

Three pounds of salt to the gallon of water will freeze at one and five-tenths degrees Fahrenheit.

Four pounds of salt to the gallon will freeze at seventeen degrees Fahrenheit below zero.

Five pounds of salt to the gallon will freeze at thirty-nine degrees Fahrenheit below zero.

It must be remembered that the more salt to the solution, the greater the electrolytic effect and the greater the liability of the deposit of salt crystals which may obstruct the free flow of the liquid.

Glycerine is usually considered quite favorably, but it has disadvantages. It often contains free acid, though the action on metals will be imperceptible in average solutions. While it does not attack metal piping to any extent it is sure destruction to rubber hose and should not be used in a car in which part of the circulation system piping is of rubber. Glycerine is expensive and it is liable to decompose under the influence of heat and pro-

portions added to the water must be higher than of some other substances.

Denatured alcohol is without doubt the best substance to use as it does not have any destructive action on the metals or rubber hose, will not form deposits of foreign matter, and has no electrolytic effect. A solution of sixty per cent. water and forty per cent. alcohol will stand twenty-five degrees below zero without freezing. The chief disadvantage to its use is that it evaporates more rapidly than water and the solution is liable to become too light as proportions of alcohol to water is concerned. The percentages required are shown in the following sentences:

Water, ninety-five per cent.; alcohol, five per cent.; freezes at twenty-five degrees Fahrenheit.

Water, eighty-five per cent.; alcohol, fifteen per cent.; freezes at eleven degrees Fahrenheit.

Water, eighty per cent.; alcohol twenty per cent.; freezes at five degrees Fahrenheit.

Water, seventy per cent.; alcohol, thirty per cent.; freezes at nine degrees Fahrenheit below zero.

Water, sixty-five per cent.; alcohol, thirty-five per cent.; freezes at sixteen degrees Fahrenheit below zero.

Various mixtures have been tried of alcohol, glycerine and water, and good results obtained. The addition of glycerine to a water-alcohol solution reduces liability of evaporation to a large extent, and when glycerine is used in such proportions it is not liable to damage the rubber hose. The proportions recommended are a solution of half glycerine and half alcohol to water. The glycerine in such a solution will remain practically the same, not being subject to evaporation, and water and alcohol must be supplied if amount of solution in radiator is not enough.

The freezing temperatures of such solutions of varying proportions are as follows:

Water, eighty-five per cent.; alcohol and glycerine, fifteen per cent.; freezes at twenty degrees Fahrenheit.

Water, seventy-five per cent.; alcohol and glycerine, twenty-five per cent.; freezes at eight degrees Fahrenheit.

Water, seventy per cent.; alcohol and glycerine, thirty per cent.; freezes at five degrees Fahrenheit below zero.

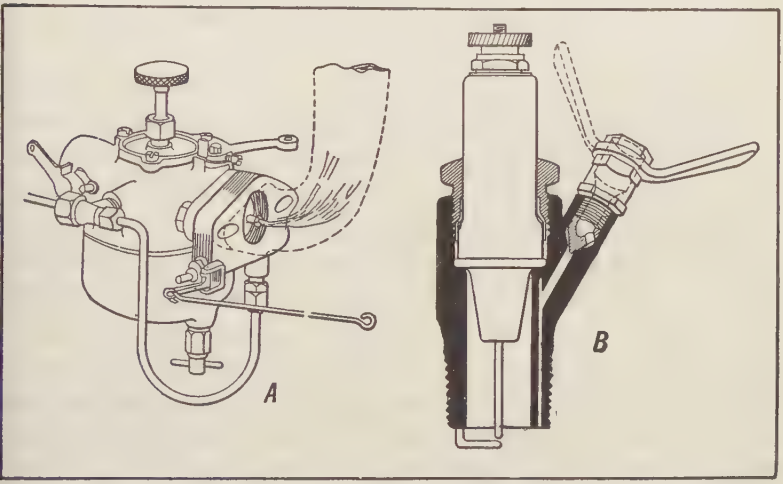

Fig. 46.—Devices to Facilitate Starting Ford Motor in Cold Weather. A.—Injex Primer. B.—Spark Plug With Priming Valve Attachment.

Water, sixty per cent.; alcohol and glycerine, forty per cent.; freezes at twenty-three degrees Fahrenheit below zero.

The proper proportions to be used must of course be governed by conditions of locality, but it is better to be safe than sorry, and make the solutions strong enough for any extreme that may be expected.

After due care has been taken with the cooling system

to prevent freezing, the next point to observe is the lubrication of the motor. This will depend on the grades of oil which are normally employed. As a general rule it is well to use a lighter grade in winter than that utilized during warmer weather. If an acetylene lighting system utilizing a gas generator is fitted it is necessary that the water used in the water tank or the water jacket provided on some generators be drained off and replaced with a solution of denatured alcohol and water of the proper consistency for the degree of temperature liable to be met with.

During cold weather, a certain amount of difficulty is always experienced in starting the car, especially when one considers the low grade of gasoline used at the present time. The Ford engine is not provided with petcocks through which gasoline may be injected as in other automobiles. Special spark plugs may be obtained having a petcock incorporated with the plug body or a special primer may be placed between the carburetor and manifold, as shown at Fig. 46. Pulling a wire when cranking a car equipped with the primer permits gasoline to flow directly to the intake manifold as shown. In extreme cold weather many motorists disconnect the fan belt in order that the air draught through the radiator will not cool the water to such a point that the engine will not run efficiently. Other motorists provide some form of a lined leather shield for the front of the radiator.

The Ford Lighting System.—The system of lighting supplied with the Ford car includes 3 oil lamps, two at the dash and one at the rear. The headlights of models made previous to 1915 are of the acetylene gas burning type deriving the gas from action of water on calcium carbide in a simple generator carried on the running

boards. Pure calcium carbide will produce about 5.5 cubic feet of gas per pound of carbide decomposed, but the commercial product seldom yields more than 4.5 cubic feet. Acetylene is a very brilliant illuminating gas and gives a white light of about 240 candlepower if burned at the rate of five cubic feet an hour. The strength of illumination can be better judged by comparing it with that produced by burning five cubic feet of good coal gas

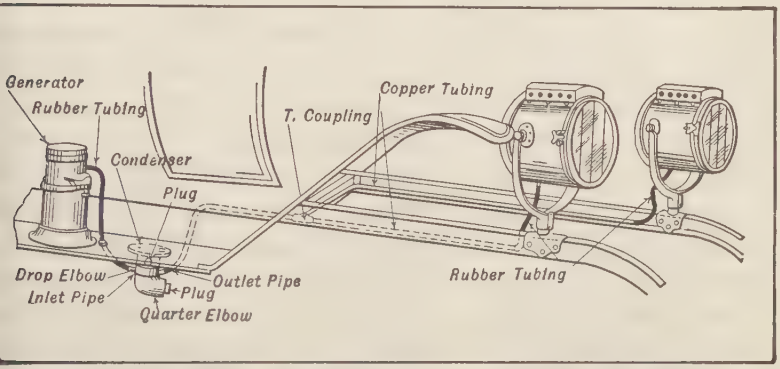

Fig. 47.—Acetylene Gas Lighting System Similar to That Used for Ford Lights on 1910 to 1914 Models. 1915 Ford Cars Have Electric Head Lights.

in the same period of time which will result in only 16 candlepower. A special form of burner is used in the Ford automobile headlights, which mixes a certain amount of air with gas and the brilliant white light produced is intensified and projected by means of a lens mirror placed at the back part of the lamp. This lens serves to collect and concentrate the rays of light from the flame into a beam composed of parallel rays which have great illuminating power, and which will light up the road for several hundred feet ahead of the car and permit higher

speeds with safety than would be possible with the feeble glimmer of oil lamps.

The generator employed and its mode of action may be easily understood. It consists of a water tank and separate compartments for carbide and as soon as the two come in contact the chemical begins to decompose and acetylene gas is liberated while lime dust collects in the bottom of the generator as a residue. The gas collects in a reservoir and forces its way through a filter chamber filled with wool or similar material which filters the gas. The gas is also cooled before it reaches the lamps because the gas outlet pipe and filter is surrounded with water. When the shut-off valve is opened it permits the water which is carried in the upper chamber to drop into the carbide basket through a perforated tube. If the pressure in the intermediate compartment is normal atmospheric pressure, the water will drop freely onto the carbide until considerable gas is liberated. The generator will continue to supply gas as long as the supply of water and carbide lasts. The jarring produced by car movement sifts the lime to the bottom, and tends to keep the carbide crystals clean so they may be readily acted upon by water. The generator must be cleaned after every trip in which it is used and all lime dust removed and carbide remaining freed of dust. The best method of piping is shown at Fig. 47, the water separator being a fitting that must be furnished by the owner as it is not supplied with the car. This keeps water out of the pipe line and prevents lamps from flickering.

Electric Lighting for Ford Cars.—Many owners of Ford cars have fitted electric lights instead of the kerosene lamps and gas lights regularly furnished up to this year. A number of attachments have been offered designed to

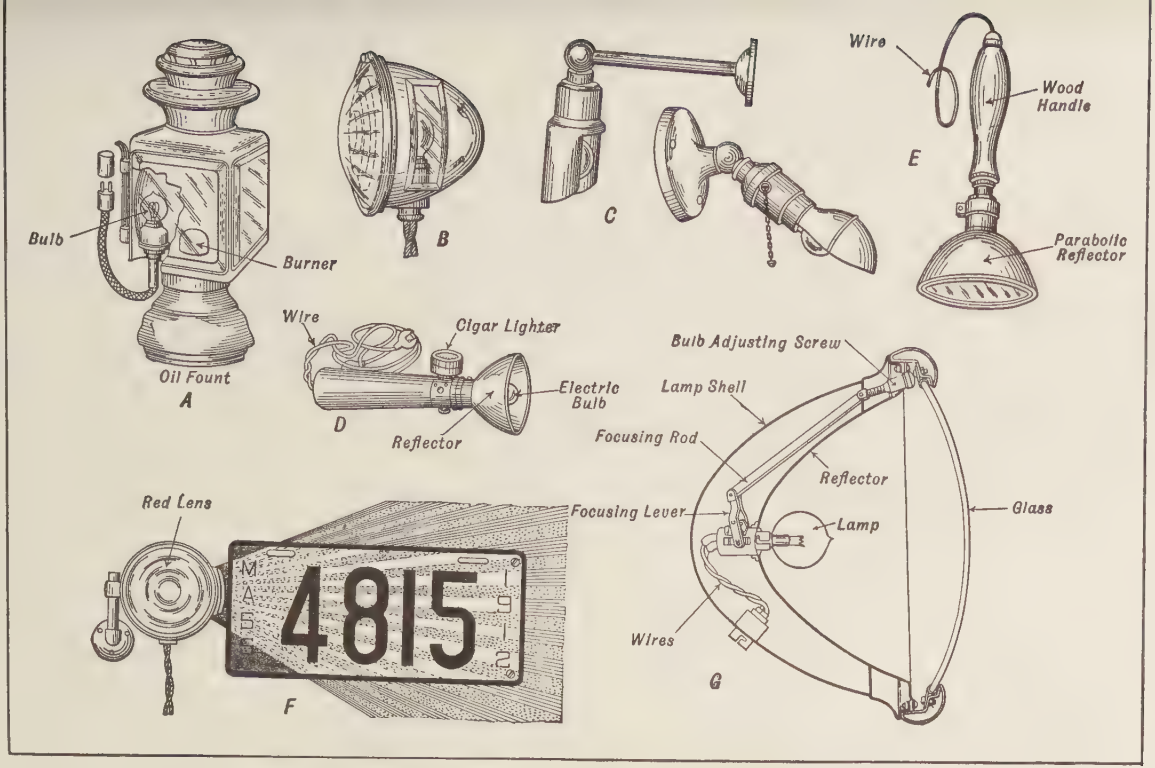

Fig. 48.—Lamps and Fixtures Adapted for Electric Current.

fit the gas head lights; these consist of parabolic reflectors and electric bulbs intended to be run from the same magneto that furnishes ignition current. Previous to the year 1915, the Ford Motor Company did not recommend the use of the magneto current for electric lighting inasmuch as it was stated that this interfered with ignition. The 1915 Ford cars, however, are equipped with electric head lamps as a regular fitting, the current being derived from the Ford magneto, which has been redesigned with a view to using larger magnets and thus producing more electrical energy than is needed for ignition purposes. As electrical lighting is general on all makes of cars and has so many advantages, many Ford owners have fitted up their own electric lighting systems by procuring fittings available on the open market. The writer desired to use electric side and tail lamps instead of the oil lamps regularly furnished, but owing to the warning of the manufacturer of the car, no attempt was made to utilize the magneto current for this purpose. A 6-volt, 80-ampere hour storage battery was installed under the rear seat to furnish current. This proved to be thoroughly practical as it was only necessary to charge the battery once a month. A number of fittings, which are illustrated as they may be of value to the Ford owner who contemplates fitting electric lighting, are shown at Fig. 48. The application of a simple fitting to convert the square oil side light to an electric side light is shown at A. This has an advantage inasmuch as the oil burner may be used in event of failure of the source of current. The same fitting may be applied to the tail lamp. At B, a very compact side light is shown. The tail light is practically the same design except that it is smaller and has a red lens instead of the white glass in the door. If electric

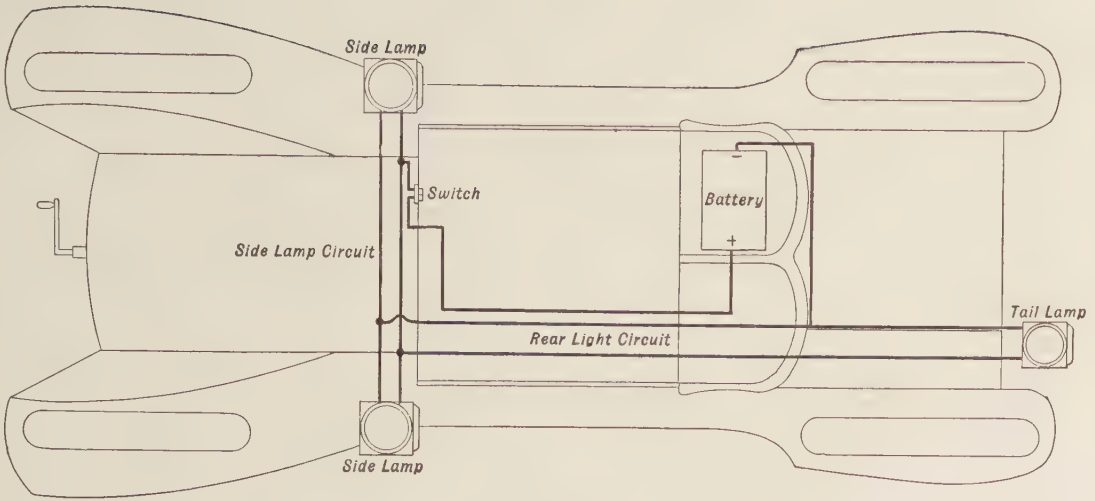

Fig. 49.—Simple Wiring Diagram Showing Method of Installing Storage Battery or Multiple-Series Dry Battery for Operating Electric Side and Tail Lamps.

current from storage battery is provided small fixtures as shown at C may be used for illuminating the speedometer dial while portable search lights such as shown at E and D will assist in locating engine trouble and repairing tires after dark. The trouble light shown at D has a cigar lighter attached which would be found very convenient by the smoker. The combination of tail lamp supporting bracket and number plate holder shown at F is also very practical fitting.

A section through a typical high grade electric head light is shown at G. This is supplied in cases where the motorist does not wish to use a make-shift reflector to convert the gas lamps. A 6-volt, 80-ampere battery will furnish enough current to operate two electric side lights, two moderate power head lights and a tail lamp for periods ranging from two weeks to a month without recharging, the service rendered being of course dependent upon the amount of night riding done. For those who wish only to use the side lamps and tail lamps of the electrical form, special low voltage bulbs may be obtained that will burn very satisfactorily on dry cell battery current. These bulbs are not sufficiently powerful for head lights, however, so some motorists fit electrical head lights taking the current from the magneto and depend on the dry battery only for the side and tail lamps. Twelve dry cells wired in series-multiple combination in which three sets of four joined in series are wired in multiple, will form a practical battery for use with the low voltage bulbs. A simple wiring diagram showing the method of coupling three lamps with the controlling switch and battery wired in is shown at Fig. 49.

The usual method of wiring head lights is to run a wire from the magneto terminal to a one point switch on

the dash, from the switch to one side of the left head light double contact bulb. The head light bulb is then joined to its neighbor, the free terminal of which is grounded to the frame side member. This means that the lamps are wired in series, this being done to permit the use of six or seven-volt lamps which are a standard, easily procured size and at the same time insures against burning them out due to excess voltage generated at high engine speeds. If the head lights are connected to the storage battery they should be wired in multiple instead of series, just as the side lamps are in Fig. 49. Separate switches should be provided for the head lights, side light, and tail lamp circuits, inasmuch as it is not necessary to use all lamps at the same time. While the tail light must be kept burning at all times, it can be used in connection with the side lamps for city driving and these can be extinguished and only the head lights used for cross country work.

Tools and Supplies for Pneumatic Tire Restoration.—It has been previously stated that one of the chief disadvantages of pneumatic tires has been their liability of failure by puncturing the outer casing and penetrating the inner tube and thus providing a means for escape of the compressed air in the inner tube. The life of a pneumatic tire is decidedly uncertain and will depend on many factors outside of those of purely natural wear. There have been cases where outer casings have given satisfactory service for seven or eight thousand miles, but these instances have been exceptions rather than the rule. It is the opinion of most motorists who have had practical experience that if an ordinary set of shoes will give a service averaging four thousand miles that they are equal to the demands made upon them and that they are satisfactory. It may be stated that tires will last longer on

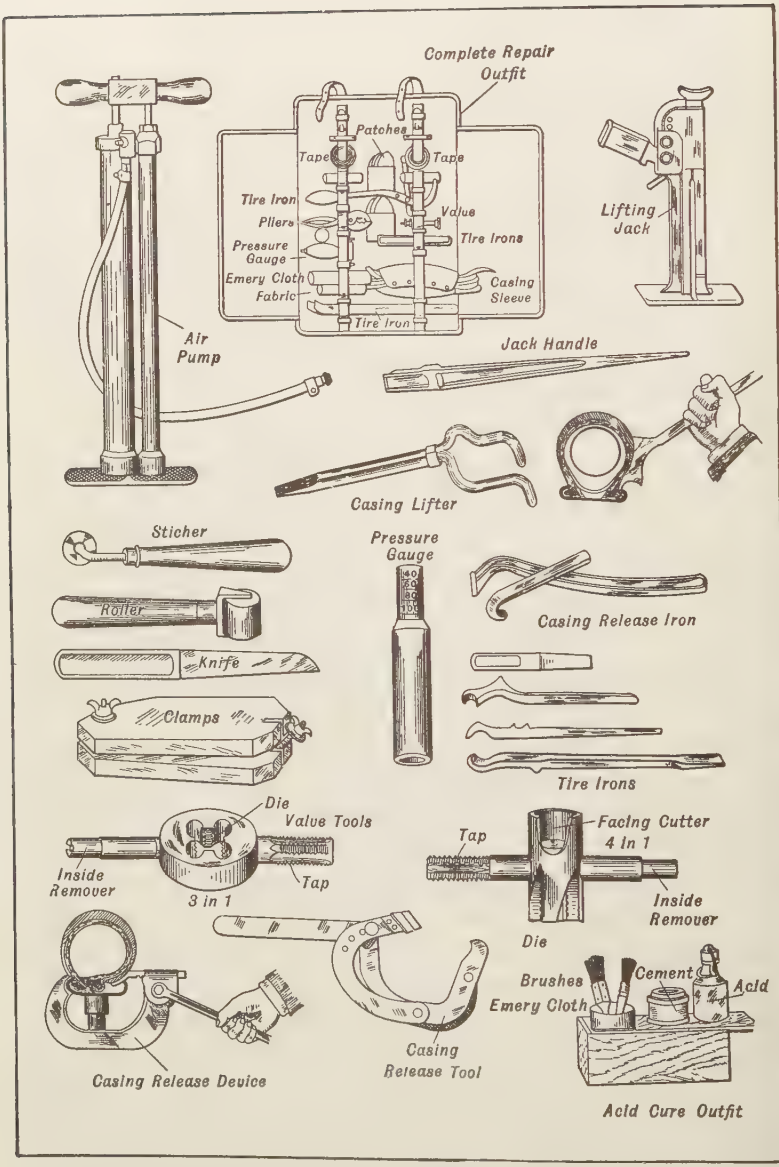

Fig. 50.—Tools and Supplies for Pneumatic Tire Maintenance, Application and Repair.

light cars like the Ford than on heavy ones and the service obtained from tires fitted to automobiles driven at low and moderate speeds will be much greater than that obtained from tires fitted to high speed vehicles. There is also a personal element which must be taken into consideration, and that is the way that the car is driven and the care taken of the shoes and inner tubes. It is necessary, therefore, in all cars using pneumatic tires to carry a certain amount of equipment for handling and repairing these on the road. A typical outfit is shown at Fig. 50, this supplementing two spare outer casings, and two extra inner tubes for replacement purposes. Included in the repair outfit are a blow-out sleeve, a number of patches and an acid-cure vulcanizing outfit for applying them. Tire irons are provided to remove the casing from the rim; the jack is used to raise the wheel of the vehicle on which the defective tire is installed from the ground and make it possible to remove the tire completely from the wheel. The air pump is needed to inflate the repaired tube or the new member inserted to take its place. Talcum powder is provided to sprinkle between the casing and the tube to prevent chafing or heating, while the spare valves and valve tool will be found useful in event of damage to that important component of the inner tube. As it is desirable to inflate the tires to a certain definite pressure, a small gauge which will show the amount of compression in the tire is useful.

The outfit shown may be supplemented by other forms of vulcanizing sets and by special tire irons to make for easier removal of the outer casing. Tire irons vary in design, and most makers of tires provide levers for manipulating the casings, which differ to some extent. A set of tire irons, such as would be needed with a clincher

tire equipment, could be selected from the forms shown at Fig. 50. That shown near the gauge is utilized to loosen the clincher bead from under the rim should it become rusted in place. After the shoe has been loosened from the rim flange, levers of the form shown at or below it would be inserted under the bead in order to lift it over the rim. Two or more of these levers are necessary, the long ones being more easily operated than the short ones. The length of the lever provided will depend entirely upon the size of the tire to be removed. Motorists, as a rule, should carry one of the releasing levers shown, two of the short members depicted and one longer lever. The latter may be a combination form, which can be used as a jack handle as well as a tire iron, and then it is not necessary to carry a jack handle in the equipment. The flattened ends are generally employed for prying the bead from the clincher rim, and when this has been done and sufficient space exists between the bead and the rim to insert the curved end of the large levers, considerable leverage is obtained and the bead may be lifted over the clincher rim without undue exertion. The object of rounding the corners, and of making the working portions as broad as possible, is to reduce the liability of pinching the inner tube, which would be present if the irons had sharp edges.

The tire repair material is sometimes carried in a special case, as shown at top of Fig. 50, this consisting of all parts necessary to make temporary repairs, to be considered in proper sequence. This outfit is sometimes supplemented by other special tools. A knife is needed to cut the rubber, trim patches, etc. The stitcher and roller are useful in rolling the patch after it has been cemented to the tire to insure adhesion of the patch firmly against the damaged portion of the tube while the cement is dry-

ing. Some motorists carry a small flame-heated vulcanizer in order to effect more permanent repairs than would be possible with the simple patching processes in which only the adhesive powers of dry cement are available.

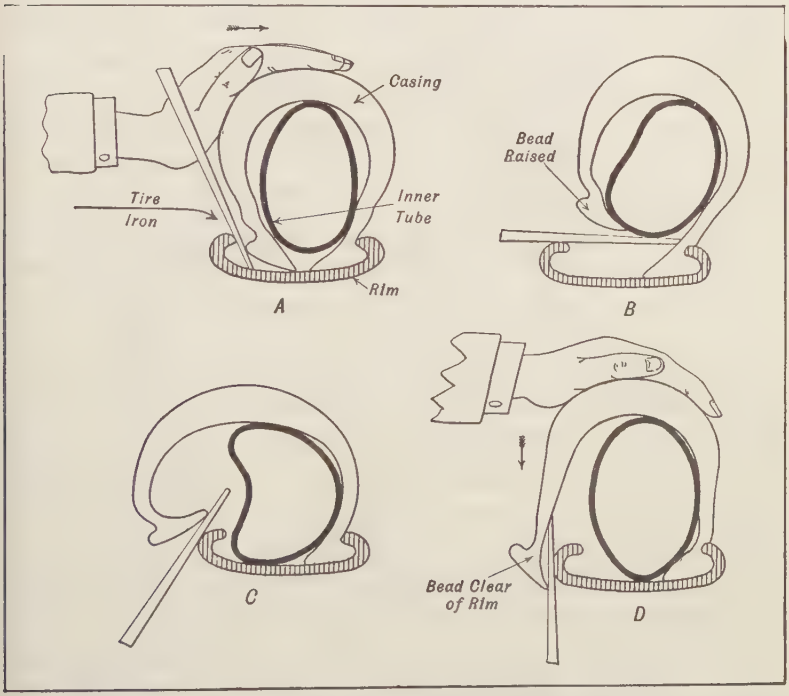

Fig. 51.—Showing Method of Releasing Clincher Casing from Rim. A.—Inserting the Tire Iron. B.—Raising the Bead. C.—Working the Clincher Bead Over the Edge of the Rim. D.—Method of Guiding Bead Over the Rim.

Tire Manipulation Hints.—In removing or replacing outer casings considerable care must be exercised not to injure the shoe or pinch the inner tube. The first step is to jack up the wheel from which the defective tire is to be removed, thus relieving the wheel of the car weight.

The valve inside is then unscrewed in order to allow any air that may remain in the tube to escape, and then the lock nuts on the valve stem are removed so that this member may be lifted to release the clincher beads from the rim channels. If the tire is stiff or has not been removed for some time, a special iron is utilized to loosen the edges and the beads are pushed clear of the clincher rim.

When the casing has been loosened on one side, a flat tool, as shown at Fig. 51, A, is inserted under the loose bead to act as a pry or lever to work the edge of the casing gradually over the rim. Very long levers are necessary to handle new stiff tires, and unused casings are particularly hard to move. The shorter irons may be employed on shoes which have been used for some time and which are more pliable than the new ones. Two of the levers are generally used together, one being kept under the loosened edge of the bead, while the other is used to force the bead over the edge of the rim. When the outside edge of the bead has been forced over the rim at all points the inner tube is lifted from the rim and is pulled out of the shoe. The start at removing is made at the point diametrically opposite the valve stem. When this portion has been pulled clear of the rim and out of the casing it is not difficult to pull the rest of the tube out and finally lift the valve stem out of the hole through which it passes in the wheel felloe, and take the inner tube entirely off the wheel. If the casing demands attention, or if a new shoe is to be used, the inside bead is worked over the channel of the clincher rim in just the same manner as was done with the outside bead, and after a start has been made and a portion of the inside bead forced over the rim there will be no difficulty in slipping the entire shoe from the wheel.

Applying a tire is just the reverse to removing one.

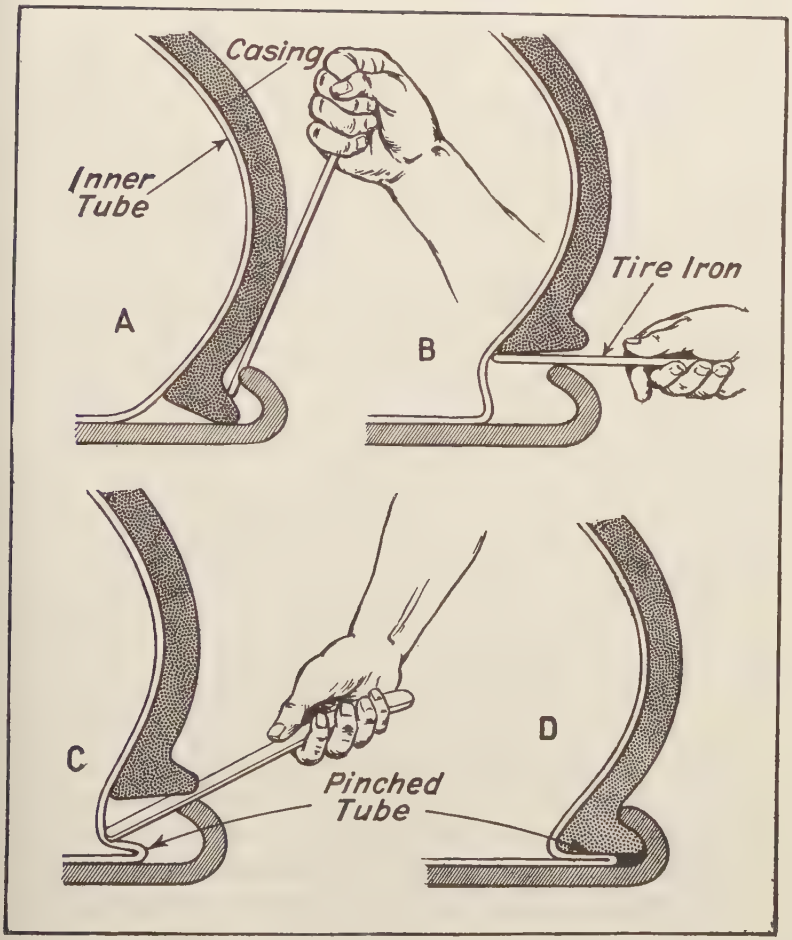

Fig. 52.—Proper Methods of Handling Tire Irons in Removing and Replacing Outer Casings on Clincher Rims at A and B. How Inner Tube May Be Pinched if Tire Iron is Carelessly Manipulated at C. Inner Tube May Be Pinched if Placed in Casing Without Being Partially Inflated as at D.

The first operation is to place the inner bead of the tire in place in the center of the rim by forcing it over the outside flange. This is done gradually, and in order to force the remaining portion of the shoe it may be necessary to use long levers when the greater part of the casing has been applied. The next step is to work the shoe gradually toward the inner channel of the rim, then to insert the air tube. The inner tube is replaced after it has been partially inflated by putting the valve stem in first and then inserting the rest of the tube, being careful not to pinch it under the beads.

After the inner tube has been put in place, the outer bead of the tire is worked over the edge of the rim channel. Care must be exercised to insure that the inner tube will not be pinched by the sharp edges of the tire levers, as at Fig 52, C. The object of partially inflating the inner tube is to distend it so there are no loose or flabby portions that are liable to catch under the tire bead when this is being forced in place over the wheel rim, as at Fig. 52, D. The conventional method of inflating tires by using a foot pump does not always insure that they will receive adequate inflation, and when a pump is employed it is imperative that some form of gauge be provided that will register the amount of pressure inside of the tire in order that it will reach the figure recommended by the tire makers. Different methods of tire inflation have been devised which eliminate the necessity of using manually operated pumps. Obviously, a simple expedient would be to provide a small power-driven pump that could be actuated by any convenient mechanical connection with the engine or a spark plug pump. Another method is to use an air bottle, which is a steel container in which air is stored under great pressure. The air is compressed to such a

point that a tank less than two feet long and six inches in diameter will furnish sufficient air to inflate seven or eight rear tires or twelve front ones. The tanks may be exchanged at small cost, when exhausted, for new containers holding a fresh supply of air. In some tanks, gases of various kinds under high pressure are used, and the motorist may obtain these on the same basis as air bottles are supplied.

All devices of this character are fitted with gauges to indicate the amount of pressure in the tire, and to prevent overinflation. If a tire is not properly inflated the shoe will be liable to various kinds of road damage and will be easily punctured, while if the pressure is too high the shoe is liable to "blow-out" at any weak point in the structure. A tire-pressure gauge is a very necessary article of equipment in any car, and its proper use when blowing up tires will insure the best possible results if the schedule recommended by the tire manufacturers is adhered to. Ford front tires should be inflated to 60 pounds, the rear ones to 70 pounds pressure. The rule is 20 pounds for every inch of tire width.

Tire Repair and Maintenance.—The common causes of tire failure that the motorist is apt to encounter are shown at Fig. 53. The most common is natural wear of the tread portion of the tire. The rubber compound in contact with the road surface wears away in time, and the fabric layers which constitute the breaker strips are exposed. The shoe is weakened and any sharp object in the road is apt to penetrate the weakened case and puncture the inner tube. If a number of the layers of fabric comprising the body of the shoe are cut this constitutes a weak place in the casing and a blow-out will result, because the few layers of fabric remaining do not have sufficient strength to resist

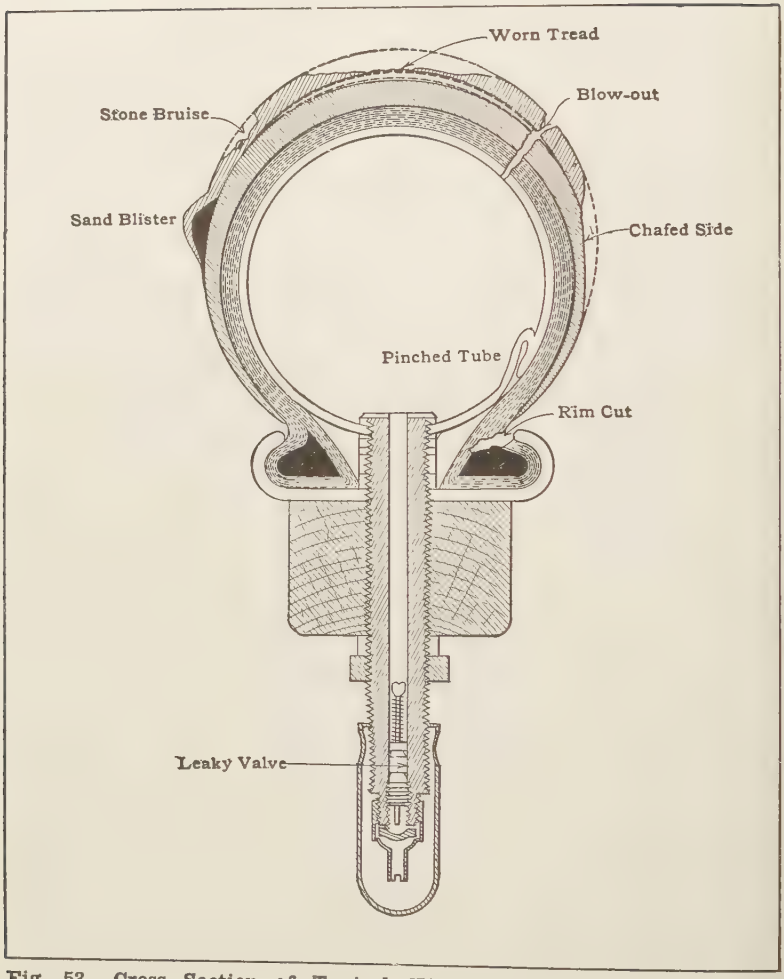

Fig. 53.—Cross Section of Typical Clincher Tire Showing Defective Points that Demand Attention When Restoring Tires to Proper Condition.

the air pressure. A stone bruise is caused by the removal of a portion of the rubber tread by a sharp stone, piece of glass, etc., and is much more serious than a puncture,

because it removes some of the tire, whereas in ordinary cases of puncture a sharp object merely penetrates the casing. A sand blister is produced by sand or grit from the road working into a space in the tire between the tread and the fabric body through some neglected incision or bruise. The side of the tread is often chafed by running the tires against curbstones or by driving in a car track. Rim cutting is generally caused by insufficient inflation, which permits the rim to cut into the tire and thus tends to sever the bead from the side of the shoe.

The chief inner tube trouble is penetration of the wall by some sharp object, or the folding over of part of the tube walls when the tire was applied. The parts of the check valve sometimes give trouble and the valve leaks. In cases of valve trouble it is usually cheaper to replace the valve inside than it is to attempt to fix it. Some of the causes of valve leakage are hardening of the rubber washer, bent stem, which prevents the valve from seating properly, or a particle of dust or other foreign matter which would act to keep the valve from closing the air passage positively.

The most serious condition that a motorist will meet with is a "blow-out," and usually only temporary repairs can be made on the road. The common methods of restoring a defective outer casing are depicted at Fig. 54. In this, an inner sleeve, which is composed of a number of plies of fabric, is placed between the inner tube and the broken portion of the outer casing to prevent pinching of the inner tube by the jagged edges of the cut. To strengthen the casing from the outside, an outer shoe or gaiter made of leather is laced around the shoe. The object of using both inside and outside reenforcing members in combination is to not only strengthen the weak

outer casing but by providing an outer shoe dirt is kept from working into the tire.

Punctured inner tubes may be temporarily repaired by using a cemented surface patch. The first step necessary is to clean the surface of the tube very thoroughly with

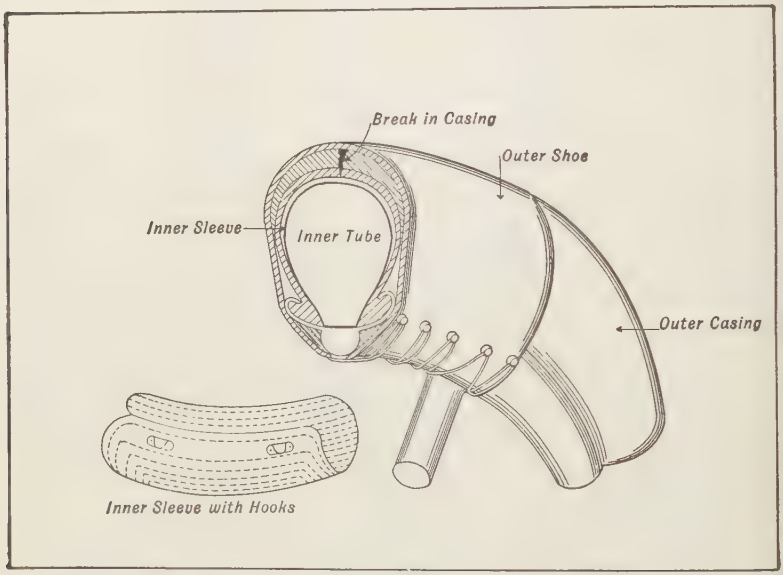

Fig. 54.—Showing the Application of Inner and Outer Casing Sleeves as a Temporary Repair for Ruptured Outer Casings.

gasoline and then to rough up the surface of both patch and that portion of the tube surrounding the hole with a wire scratch brush or with sandpaper. After the surfaces are properly cleaned and roughened the patch and the tube are coated with suitable patching cement, which is allowed to become thoroughly dry before the second coat is applied. The second coat is allowed to become "tacky," which expresses a condition where the cement is almost

dry and yet still possesses a certain degree of adhesiveness. This requires about ten minutes' time on an average. The patch is applied to the cemented portion of the tube and the whole is clamped firmly together to secure positive adhesion while the cementing medium is drying. Patches should always be of sufficient size to cover the damaged portion and at the same time have about three-quarters of an inch or more of the patch at all sides of the orifice.

Very satisfactory repairs to both inner and outer casings of a permanent nature can be made by using small portable vulcanizers, which may be heated by either electricity, steam or by burning gasoline in them. When these are used a special vulcanizing cement is necessary, and uncured rubber stock must be used for patching or filling openings caused by punctures or blow-outs. The patch of raw material is applied to the cemented surface of tube or casing and the vulcanizer heated to the proper temperature. The heat of the vulcanizer causes the rubber of the patch to unite perfectly with the old material and forms an intimate bond. In vulcanizing the most important precaution is to maintain a proper temperature. Too great a degree of heat will burn the rubber, while a proper cure cannot be effected if the temperature is too low. The temperatures recommended for vulcanizing vary from 250 to 325 degrees F. The lower degree of heat is used for working material that has been previously cured, while the higher temperature is recommended for new rubber.

The rules to secure satisfactory operation from pneumatic tires may be easily summed up. In the first place, it is imperative that the tires be inflated to the pressures recommended by the manufacturers. The tires should be kept clean and free from oil or grease, because the oleagi-

nous substances used for lubrication very quickly attack rubber compounds and cause crumbling and rapid deterioration. Oil or grease should be wiped off as soon as noticed and the tire cleaned by application of gasoline. Any small cuts or openings in the tire that may permit water to enter or sand to work between the fabric and the tread will cause trouble in time and should be filled with rubber compound as soon as noticed. One should be careful in driving not to apply the brakes too suddenly, because this will lock the wheels and wear the tires flat in spots very quickly. Care should be taken not to drive in car tracks, and when highways do not have the proper surface they should be negotiated very carefully to avoid cutting the casings.

Typical Special Tool Equipment.—The makers of all the popular cars, especially those that are produced in any quantity, furnish special tools for the use of their repair men or for those employed in the service stations of the agents. As an example of the special tools that it is possible to obtain the assortment used by repairmen of Ford Model T cars is shown at Fig. 55. The device at A is a wheel puller designed to go on the hub in place of the hub cap. The tools shown at B, C, D, F, G and D2 form part of the regular tool equipment. The box wrench at E is also furnished with each car, and is a hub cap wrench having one end formed to fit the slabbed portion of the front wheel bearing adjusting cone lock nut.

A valve spring lifter is shown at H, while a valve seat reamer is shown at I. The valves are turned while grinding by the special brace S, which can be used on all of the valves except the one on the rear cylinder, which is immediately under the dash board. To turn this valve the special wrench shown at L is provided. A special T handle

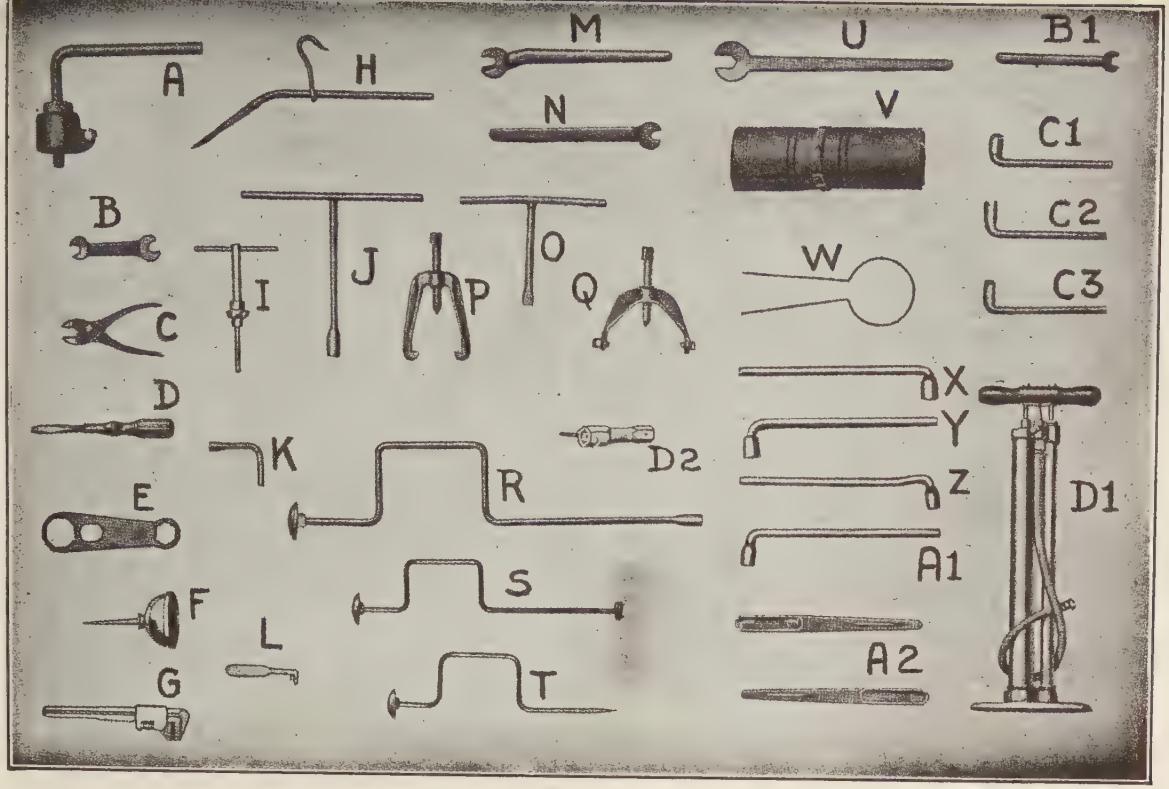

Fig. 55.—Special Tool Outfit for Repairing Ford Cars.

socket wrench for handling ⅜″ nuts or bolt heads such as used on the rear construction and various other points is shown at J. A T handle screw driver for the set screws which are employed in retaining the camshaft bearings is shown at O. The puller shown at E is for removing the cam gear from the camshaft, while that at Q is a transmission clutch puller. The brace shown at R is a special socket wrench for ⅜″ bolt nuts. The brace shown at T is employed for removing the magnet retaining screws in the magneto assembly. The tire irons at A-2, the tool roll at B, the pump at D-1 and the spark plug socket wrench at D-2 are all parts of the regular tool equipment furnished with each car.

The simple fitting shown at W is a piston ring compressor employed to compress the rings in the piston grooves to facilitate easy assembly in the cylinder block. A number of special socket wrenches are shown at X, Y, Z, A-1, C-1, C-2 and C-3. These are all intended for use on the various fastenings used in holding the parts together. For example, that at X is a socket wrench for the crank shaft main bearing bolt nuts. That at Y is for ⅜″ bolt heads or nuts. The wrench at Z is for removing the cylinder head retaining bolts. The wrench for removing the pinion drive shaft housing retaining stud nuts is shown at C-1, this being used for ⅜″ nuts. The rear axle housing bolt nut wrench is shown at C-2, while the form outlined at C-3 is similar to that shown at C-1, except that it fits $1\frac{1}{32}$″ nuts. The special end wrench at M is for the flywheel retention cap screws, that at U is for removing the large cam gear lock nut, while that at B-1 is a regular open end wrench for ⅜″ nuts. The prices on these tools are so low that it is cheaper to purchase from the factory than to attempt to make them.

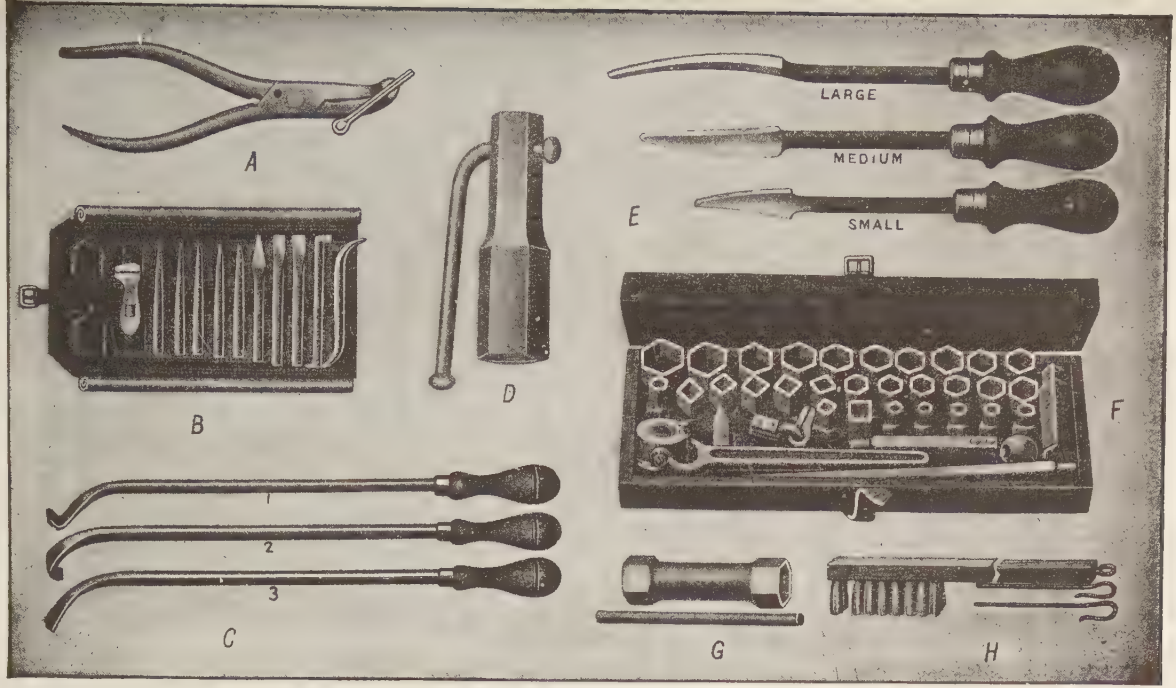

Fig. 56.—Tools That Will Be Valuable When Overhauling or Repairing Ford Automobiles. A.—Special Pliers for Removing and Inserting Split Pins. B.—Chisel and Punch Set. C.—Carbon Scrapers. D.—Socket Wrench. E.—Bearing Scrapers. F.—Ratchet and Socket Wrench Set. G.—Double End Box Wrench. H.—Spark Plug Brush.

A Typical Engine Stoppage Analyzed.—Before describing the points that may fail in the various auxiliary systems, it will be well to assume a typical case of engine failure and show the process of locating the trouble in a systematic manner by indicating the various steps which are in logical order and which could reasonably be followed. In any case of engine failure the ignition system, motor compression and carburetion should be tested first. If the ignition system is functioning properly one should determine the amount of compression in all cylinders, and if this is satisfactory the carbureting group should be tested. If the ignition system is working properly and there is a decided resistance in the cylinders when the starting handle is turned, proving that there is good compression, one may suspect the carburetor.

It is possible that the inlet manifold may be loosely held or cracked, that an exhaust valve is stuck on its seat because of a broken or bent stem. Failure of the cam-shaft drive because the teeth are stripped from the engine shaft or cam-shaft gears; or because the key or other fastening on either gear has failed, allowing that member to turn independently of the shaft to which it normally is attached, is very rare. The gasoline feed pipe may be clogged or broken, the fuel supply may be depleted, or the shut-off cock in the gasoline line may have jarred closed. The gasoline filter screen or sediment bulb may be filled with dirt or water, which prevents passage of the fuel. The defects outlined above, except the failure of the gasoline supply, are uncommon, and if the container is found to contain fuel and the pipe line to be clear to the carburetor, it is safe to assume that the vaporizing device is at fault. If fuel continually runs out of the mixing chamber the carburetor is said to be flooded. This condition results from

failure of the shut-off needle to seat properly or from a gasoline soaked cork float. It is possible that not enough gasoline is present in the float chamber. If the passage controlled by the float needle valve is clogged or if the float was badly out of adjustment, this contingency would be probable. When the carburetor is examined, if the gasoline level appears to be at the proper height, one may suspect that a particle of lint, dust, fine scale or rust from the gasoline tank has clogged the bore of the fuel passage.

On cranking the motor slowly over by hand, if one cylinder has poor compression while all others have good compression the trouble may be due to a defective condition either inside or outside of that cylinder. The external parts may be inspected more easily, so the following should be looked for: a broken valve, a warped valve head, broken valve springs, sticking or bent valve stems, dirt under valve seat, leak at cylinder head packing or spark plug gasket, cracked cylinder head (rarely occurs), leak through cracked spark plug insulation, valve plunger stuck in the guide, lack of clearance between valve-stem end and top of plunger. The faulty compression may be due to defects inside the motor. The piston head may be cracked (rarely occurs), piston rings may have lost their elasticity or have become gummed in the grooves of the piston or the piston and cylinder walls may be badly scored by a loose wrist pin or by defective lubrication. The Ford motor is a type with a separately cast head and it is possible that the gasket or packing between the cylinder and combustion chamber may leak, either admitting water to the cylinder or allowing compression to escape. This may be corrected by tightening all the retaining bolts firmly to seat the head against the gasket.

Conditions That Cause Failure of Ignition System.—If the first test of the motor had showed that the compression was as it should be and that there was no serious mechanical defects and there was plenty of gasoline at the carburetor, this would have demonstrated that the ignition system was not functioning properly. If a battery is employed as an auxiliary supply of current, the first step is

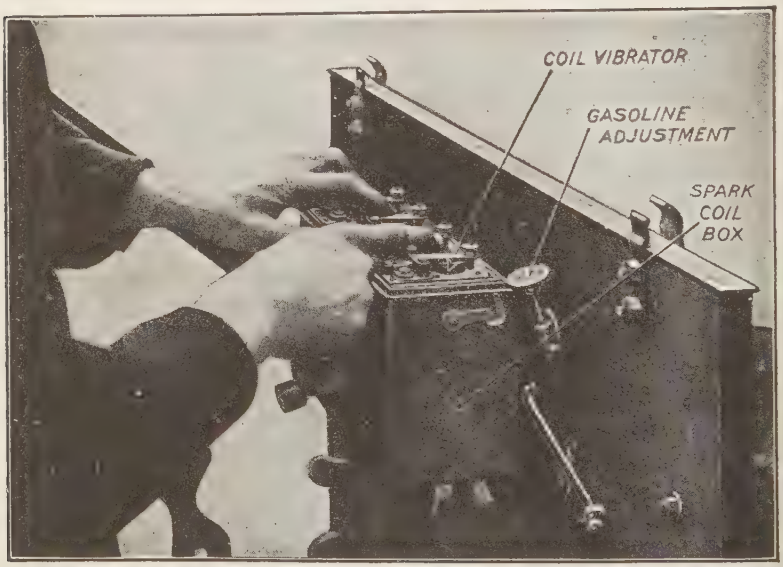

Fig. 57.—Method of Testing Regularity of Engine Action by Holding Down Coil Vibrators.

to take the spark plugs out of the cylinders and test the system by turning over the engine by hand, with the switch circuit closed. If there is no spark in any of the plugs, this may be considered a positive indication that there is a broken main current lead from the battery, a defective ground connection, a loose battery terminal, or a broken cell connector. If none of these conditions are present, it

is safe to say that the battery is no longer capable of delivering current. If there is no spark at the plugs, but the spark-coil vibrator functions properly, this shows that the primary wiring is as it should be and that the fault

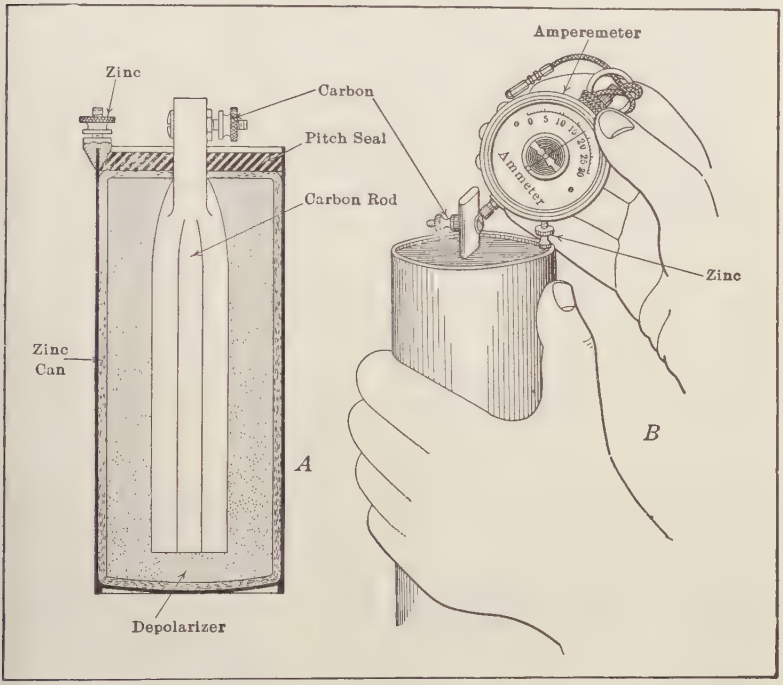

Fig. 58.—Sectional View of Dry Cell Showing Interior Construction at A and Method of Testing Current Output With Amperemeter at B.

must be looked for in either the wires comprising the secondary circuit, or at the plugs. The spark plugs may be short circuited by cracked insulation or carbon and oil deposits around the electrodes. The secondary wires may be broken or have defective insulation, which permits the current to ground to some metal part of the frame or motor. The battery strength should be tested with a volt

or ampere meter to determine if the voltage and amperage is sufficient. Storage battery capacity is usually gauged by measuring the voltage, while dry cells are judged by their amperage. A storage battery should show over two volts per cell or 6.5 volts in a three-cell group, while dry batteries that indicate less than six amperes per cell are not considered reliable or satisfactory for ignition service. Look also at the magneto contact plunger to make sure it is clean and not gummed up or held away from its seat by a small shred from the brake lining. If there is no vibration at the coil tremblers the trouble may be due to weak current source, broken or loose magneto wire, broken timer wires, or defective connections at the vibrator or commutator contact points. The electrodes of the spark plug may be too far apart to permit a spark to overcome the resistance of the compressed gas, even if a spark jumps the air space when the plug is laid on the cylinder. In some cases the trouble has been due to the switch, which did not contact properly. In others, the spring keeping the timer case in place loosened and the timer case was not making proper contact with engine. It should always be in firm contact with the engine base to secure positive electrical contact between timer roll carrier and segments in timer case.

If the motor runs intermittently, i.e., starts and runs only a few revolutions, aside from the conditions previously outlined, defective operation may be due to seizing between parts because of insufficient oil or deficient cooling, too much oil in the crank case, which fouls the cylinders after the crank has revolved a few turns, and derangements in the ignition or carburetion systems that may be easily remedied. There are a number of defective conditions which may exist in the ignition group, that will result

in "skipping" or irregular operation, and the following is the logical order in which the various points should be inspected: the parts which demand inspection oftenest are considered first; weak source of current due to worn-out dry cells or discharged storage batteries; weak magnets in magneto; dirt or gummed oil in timer casing, broken spring on timer roll carrier, or poor contact at magneto current collecting plunger. A dirty or cracked insulator at spark plug will cause short circuit, and can only be detected by careful examination. The following points should also be checked over when the plug is inspected: Excessive space between electrodes, points too close together, loose central electrodes, or loose point on plug body, soot or oil particles between electrodes, or on the surface of the insulator.

How To Locate "Skipping" Cylinder.—If irregular engine action is due to poor ignition and the trouble seems localized to some particular cylinder, it is very easy to locate the member at fault by holding down the coil vibrators as shown at Fig. 57. The engine is run with a late spark and with the throttle about half open and three of the vibrators are held down at a time, leaving the engine running on one cylinder only. It may often be found that three of the cylinders are functioning properly and that only one is at fault, which in this case means that the trouble is present either at the spark plug or to some condition in that cylinder other than faulty ignition. The engine will run on one cylinder when three of the coil vibrators are held down, the object being to discover the weak or faulty cylinder by putting those that are running properly out of action temporarily. When all three vibrators that belong to the cylinders that are working properly are held down the engine will not run with the vibrator serving the

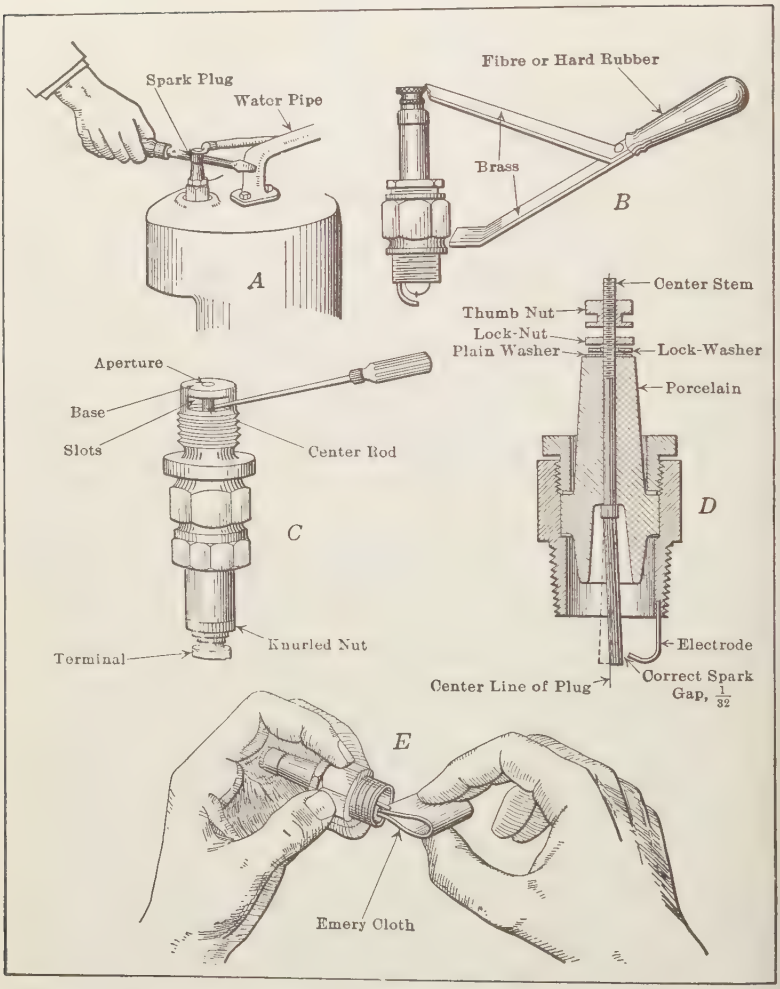

Fig. 59.—Showing Methods of Adjusting Air Gaps in Spark Plugs.

cylinder that is at fault free. Some repairmen hold down only two of the vibrators and let the engine run on the remaining one or two cylinders. This is in cases where

the mixture adjustment may be faulty enough so that one cylinder will not suffice to keep the engine in operation.

Spark Plug Faults.—After the "missing" cylinder has been located either by the method of holding down the vibrators or by short circuiting each of the cylinders in turn by using a screw driver as indicated at Fig. 59, A to connect the insulated terminal of the spark plug to some metal portion of the engine, the next step is to remove the spark plug and examine it carefully for various faults. On some cars using high tension magneto ignition and on some Fords that have been fitted over in this way by their owners it is not easy to detect irregular engine action, as no vibrators are used that may be utilized as indicators of correct engine action. In this case the simple tool shown at Fig. 59, B may be used. This consists of two strips of brass riveted together and fastened into a fiber or hard rubber handle as shown. These make a very effective short circuiting medium and entirely eliminate the danger of shock present when a screw driver is used for this purpose. If the plug is dirty the point should be cleaned with an old toothbrush dipped in gasoline or with a special spark plug brush made for the purpose as outlined at Fig. 56, H.

If the plug is extremely dirty it should be taken apart, which should be easily done by removing the porcelain retaining bushing that fits the main steel shell and then taking the porcelain out of the shell member. Care should be taken not to drop any of the copper asbestos gaskets used on both sides of the porcelain shoulder. The carbon deposits, which are usually of an oily nature, may be easily removed from the porcelain or shell interior with the small blade of a jack knife, but care should be taken not to scratch the glazed surface of the porcelain, as this permits

the insulator to absorb oil. All parts of the plug should be thoroughly washed with gasoline and wiped dry with a clean rag. When reassembling the plugs care should be taken that the bushing holding the porcelain in place is not tightened too much, as this may crack the insulator. It is also important that the distance between the spark points should be no more than $\frac{1}{32}$", which is about the thickness of a worn dime. Some plugs have a center terminal, as shown at Fig. 59, C. These are easily handled by pushing the center rod over until it bears the proper relation to the aperture in the plug base.

The standard form of plug used on Ford cars is shown at Fig. 59, D. With this construction the air gap is maintained at the proper point by moving the center stem as conditions demand. A cracked insulator must be replaced with a new one, and if the bent electrode is found loose in the plug shell this should be firmly retained in place by jamming a portion of the metal surrounding it toward the wire with a sharp prick punch. The method of using a doubled over piece of fine emery cloth to brighten the plug points to insure the easy passage of the ignition spark is clearly shown at Fig. 59, E. The spark plug should be tested after it is assembled by connecting it to the spark plug wire and laying it on the cylinder in such a way that only the steel shell is in contact with the metal parts of the engine. The engine is then cranked over by hand with the switch on the coil box in the battery position if these members are provided and the plug watched to see if a spark occurs between the points at regular intervals. If the spark plugs foul up quickly the trouble is usually due to too much lubricating oil in the engine, worn piston rings, which allow the oil to reach the combustion chambers, the use of poor quality oil or too rich fuel mixture.

Faults in Other Ignition System Parts.—When testing a dry battery, the terminals should be gone over carefully to make sure that all terminal nuts are tight and that there are no loose or broken connectors. The wiring at the coil, timer, and switch should be inspected to see that all connections are tight and that the insulation is not chafed or cracked. Defective insulation will allow leakage of current, while loose connections make for irregular operation. In testing a storage battery care should be taken to remove all the verdigris, or sulphate, from the terminals before attaching the testing wires. The strength of the Ford magneto can be determined by the Hoyt magnetometer, a device specially made for this purpose. In the Ford system a vibrator coil is employed, so the trembler platinum contact points should be examined for pits, or carbonized particles that would interfere with good contact. If defective, they should be thoroughly cleaned and the surfaces of the platinum point on both vibrator spring and adjusting screw should be filed smooth to insure positive contact. The tension of the vibrator spring should not be too light or too heavy, and the vibrator should work rapidly enough to make a sharp, buzzing sound when contact is established at the timer. The adjusting screw should be tight in the vibrator bridge, and when proper spring tension is obtained the regulating screw should be locked firmly to prevent movement, if an automatic lock is not provided, as on Heinze coils.

If the vibrator operates satisfactorily, but there is a brilliant spark between the vibrator points and a poor spark at the spark plug, one may assume that the coil condenser is punctured. Short circuits in the condenser or internal wiring of induction coils or magnetos, which are fortunately not common, can seldom be remedied ex-

cept at the factory where these devices were made. If an engine stops suddenly and the defect is in the ignition system, the trouble is usually never more serious than a broken or loose wire. This may be easily located by inspecting the wiring at the terminals. Irregular operation or misfiring is harder to locate, because the trouble can only be found after the many possible defective conditions have been checked over, one by one.

Common Defects in Fuel Systems.—Defective carburetion often causes misfiring or irregular operation. The derangements of the components of fuel system that are common enough to warrant suspicion and the best methods for their location follows: First, disconnect the feed pipe from the carburetor and see if the gasoline flows freely from the tank when the shut-off valve is opened again. If the stream coming out of the pipe is not the full size of the orifice it is an indication that the pipe is clogged with dirt or that there is an accumulation of rust, scale, or lint in the strainer screen of the filter or that the sediment bulb is filled with foreign matter. It is also possible that the fuel shut-off valve may be wholly or partly closed. When the gasoline flows by gravity the liquid may be air bound in the tank on account of a plugged vent hole in filler cap.

If the gasoline flows from the pipe in a steady stream the carburetor demands examination. There may be dirt or water in the float chamber, which will constrict the passage between the float chamber and the spray opening, or a particle of foreign matter may have entered and clogged the fuel inlet. The float lever may bind on its guide pin, the needle valve regulating the gasoline inlet opening in bowl may stick to its seat. Any of the conditions mentioned would cut down the gasoline supply and the engine

would not receive sufficient quantities of gas. The gasoline adjusting needle may be loose and jar out of adjustment. Air may leak in through the manifold, due to a porous casting, or leaky joints due to poor gaskets or loose retaining stirrups and dilute the mixture. Water or sediment in the gasoline will cause misfiring because the fuel feed varies when the water or dirt constricts the pipe bore.

It is possible that the carburetor may be out of adjustment. If clouds of black smoke are emitted at the exhaust pipe it is a positive indication that too much gasoline is being supplied the mixture, and the supply should be cut down by screwing down the needle valve and by making sure that the fuel level is at the proper height in the float bowl. If the mixture contains too much air there will be a pronounced popping back in the carburetor. When a carburetor is properly adjusted and the mixture delivered to the cylinders burns properly, the exhaust gas will be clean and free from the objectionable odor present when gasoline is burned in excess. If the muffler cut-out has been provided by the owner the character of combustion may be judged by the color of the flame which issues from it when the engine is running with an open throttle after nightfall. If the flame is red, it indicates too much gasoline. If yellowish, it shows an excess of air, while a properly proportioned mixture will be evidenced by a blue flame, such as given by a gas stove burner.

Defects in Oiling and Cooling Systems.—While troubles existing in the ignition or carburetion groups are usually denoted by imperfect operation of the motor, such as lost power and misfiring, derangements of the lubrication or cooling systems are usually evident by overheating, diminution in engine capacity, or noisy operation. Over-heating may be caused by poor carburetion as much as by

deficient cooling or insufficient oiling. When the oiling group is not functioning as it should the friction between the motor parts produces heat. If the cooling system is in proper condition, as will be evidenced by the height of the water in the radiator, and the carburetion group appears to be in good condition, the overheating is probably caused by some defect in the oiling system.

The Ford oiling system is so simple that practically the only condition that will cause defective oiling is lack of oil in the engine case or the use of poor grade lubricant. The use of dirty oil will also produce overheating and may result in trouble with bearings or cylinder walls cutting. Grooved cylinder walls permit the hot gases to blow by the piston rings and overheating results. Sometimes the internal oil conduit or pipe running from the back end of the crank case to the front may be partially clogged with gummed oil or wax particles from the oil. This pipe should be cleaned out by a blast of compressed air at high pressure from time to time. It can be reached from the top of gear case when the cover casting is removed. The oil collecting wells that direct the lubricant to the main bearings may fill with dirt or other matter, such as gummed oil, which prevents proper quantities from reaching the bearings. This condition is apt to occur if the crank case is not drained out and cleaned from time to time as recommended.

Deposits in Radiator and Piping.—The form of radiator most generally used at the present time has a number of very narrow passages through which the water must pass in going from the upper compartment, into which it is discharged after leaving the motor cylinders to the lower compartment, where it collects after being cooled and from which it is drawn by the circulating pump. The

water used in some localities for cooling contains much matter, either in suspension or solution, which will form scale or a powdery deposit in the radiator tubes. It does not take much scale to seriously reduce the ratio of heat conduction between the heated water inside of the tube and the cooling air currents which are circulated about their exterior. As Ford cylinders are of cast iron, a certain amount of rust will be present in the water jacket, and this also may get into the radiator piping.

If an anti-freezing solution using some salt as a basis, such as calcium chloride, is employed, after this has been circulated through the radiator and piping for a time it may deposit solid matter in the form of crystals. Anti-freezing solutions that include glycerine may have a chemical action due to the acid sometimes found in the cheaper commercial grades of glycerine employed for this purpose. This chemical action results in the deterioration of the water jacket walls, and also contributes to the rust deposit.

For cleaning out water spaces of a radiator a solution of potash or caustic soda may be used. This will cut the rust and some forms of scale, and will dissolve them or loosen them sufficiently so the deposits may be thoroughly flushed out with water or steam under pressure. The solution will work more rapidly if it is brought to the boiling point before placing it in the radiator. The solution is also valuable in removing rust from the water jacket interior. The best action is obtained if the caustic soda solution has a strength of between 15 and 22 per cent.

In order to apply this method, the whole of the water in the circulating system is drained off and measured. Then a solution is made by dissolving 2½ lbs. of solid caustic soda so that it makes one gallon of solution, enough of the solution being made to fill the entire cooling system.

Considerable heat is generated when the soda is dissolved, and frequent stirring is necessary, unless the soda is hung in an iron basket just under the surface of the liquid. When the liquid has cooled it is introduced into the circulating system until the latter is entirely filled. The soda is allowed to remain in the system all night and is run out in the morning. It must be borne in mind that caustic soda will corrode aluminum in other cars and must not be used if the system should have an aluminum pump housing. After running out the soda a hose pipe and water supply should be connected to the system and a good stream of water driven through at fair pressure for some time. It will not harm Ford parts.

Incrustation is most commonly caused by carbonate of lime, which is held in solution in some waters as a bicarbonate; therefore, when the water is heated the carbonic acid is driven off and the carbonate is precipitated in the form of a muddy deposit, which hardens in the presence of heat into a non-conducting scale in those portions of the water jacket where the heat is greatest and which remains in the form of a powdery deposit in the radiator tubes, where the heat is not great enough to harden the sediment. Sometimes the deposit is sulphate of lime, this also being found in the water available in some localities. The reason that water contains so many impurities is because it is one of the best known solvents. Pure water is never found in nature and can only be obtained by a process of distillation. The purest natural water is rain, and if this is collected before it touches the earth it contains only such impurities as may be in the air.

Method of Fan Belt Adjustment.—If the motor heats up when the engine is running and the car standing still, it is necessary to inspect the fan driving means to make

sure that this is functioning properly and that the fan is turning all the time the engine is running and at the proper speed. Ford cooling fans are flat belt driven and are mounted on a simple form of bracket that will permit of maintaining the fan driving belt at the proper tension to insure positive rotation of the fan blades.

The fan belt tension may be easily adjusted by loosening a lock nut on a cap screw which bears against the lever carrying the fan hub and tightening down on the belt tension regulating screw until the belt is tight enough so that a decided resistance will be felt due to fan belt friction when the fan is turned by hand. Care should be taken not to tighten the fan belt too much, however, as this will result in rapid wear of the belt and cause it to stretch as well as imposing some strain on the fan hub bearing. The adjusting screw in the fan bracket may be easily reached by removing the small brass cap which covers the breather pipe at the front end of the engine. If the water in the radiator boils easily and the trouble is not due to heavy work, it is usually because the fan belt is loose.

Among some of the troubles that will cause overheating are: too much driving on low speed; not enough lubricating oil; carbonized cylinders or combustion chambers; spark retarded too far; clogged muffler; insufficient lift to exhaust valves, poor carburetor adjustment, clogged radiator tubes, fan not working properly on account of broken or slipping belt, and leaky piston rings. In examining the cooling system, one should look for a leaky radiator, jammed or broken radiator pipes, bad connections in the rubber hose used to join radiator and water jacket, lack of water and sediment in radiator or water jacket. The Ford Company does not advise the use of nostrums such as corn meal, bran or other substances put

into the radiator for the purpose of stopping leaks, as these are bound to hinder proper circulation. The interior walls of the rubber hose may decompose and particles of rubber hang down, partially constricting the hose bore and hindering the passage of water. As new hose connections are inexpensive and easily applied, defective members should be replaced at once.

Adjusting Transmission.—If any difficulty is experienced in climbing hills on the high speed and the engine seems to have adequate power it is because the high speed clutch is slipping. If the engine races when the slow speed pedal is pushed up as tight as it will go when climbing steep hills it is because the slow speed band in the transmission needs adjusting. Should the car show a tendency to creep forward when the crank is turned for starting the motor, this indicates that the clutch lever screw which bears on the clutch lever cam has worn and requires an extra turn down to hold the clutch in neutral position. This screw and the cam on which it works are clearly shown in the lower portion of Fig. 60. As will be observed, the screw passes through a boss on the end of a simple lever, the other end of which is joined to the clutch actuating pedal by a simple rod and yoke connection. The lock nut must be released before attempt is made to screw down the clutch lever screw, and care must be taken not to screw that down any more than absolutely necessary or the high speed clutch will slip.

To make adjustments to the reverse or transmission brake band, or to the high speed clutch, the plate on the transmission cover must be removed, this exposing the interior of the transmission, as shown at Fig. 60. It will be necessary to remove the floor boards of the car to get at this portion of the power plant. In order to simplify the

Fig. 60.—Method of Adjusting Transmission Brake Band.

point involved, the method of adjusting a high speed clutch is shown at Fig. 61, in which the top half of the transmission case has been entirely removed. It will be noticed that there are three clutch fingers spaced around the front end of the transmission drum. These have set screws,

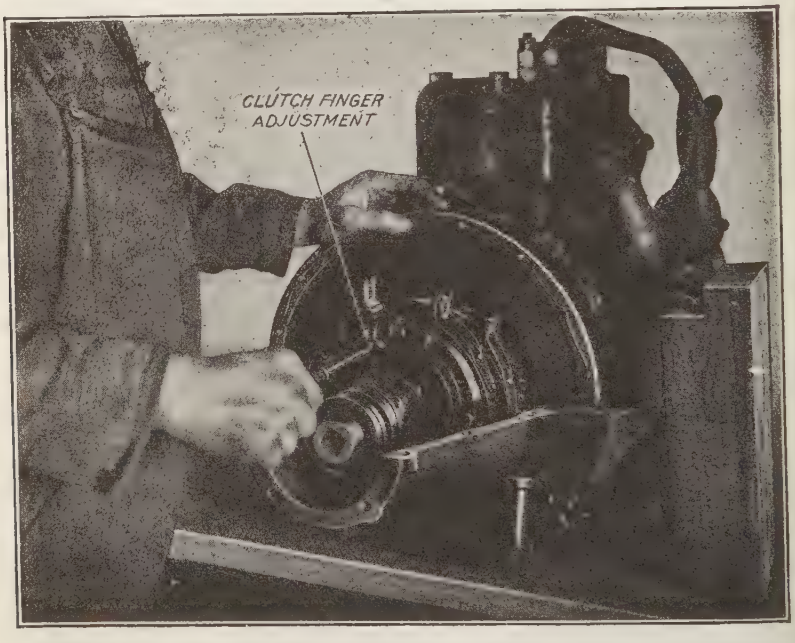

Fig. 61.—How to Tighten Slipping High Speed Clutch.

through which the pressure of the spring is translated to push members bearing against the clutch disc assembly. These set screws are prevented from turning by split pin locks. If the high speed clutch is slipping, the split pin on the clutch finger that locks the set screw should be removed and the set screw given one-half or one complete turn to the right with a screw driver. Each of the other

set screws should be turned exactly the same amount, and care should be taken to replace the locking split pin.

The low speed band may be tightened without removing the transmission cover plate, as an adjusting screw is provided outside of the transmission case and on the right hand side. If the slow speed band does not hold positively the lock nut on this adjusting screw may be loosened and the screw turned toward the right until appreciable resistance is felt when the clutch pedal is pushed way forward. This adjusting screw is shown in the space between the transmission case and the exhaust pipe in Fig. 60. The foot brake and reverse bands cannot be adjusted without removing the transmission case cover plate, as shown at Fig. 60. Adjusting nuts will be found that may be readily turned with an S wrench, as indicated, until the proper degree of band tension has been obtained by bringing the ends closer together. Care should be taken not to tighten the bands too much, as they may drag on the transmission drum assembly when the car is in the high speed, act as a brake and tend to overheat the motor. The foot brake should be adjusted tightly enough, however, so that medium pressure on the foot pedal will stop the car immediately or slide the rear wheels in case of emergency. The reverse band should be tightened in the same way as the brake band is. If the friction linings of the bands are worn to such an extent that adjusting the brake does not seem to improve matters, they should be removed and relined with new friction material so they will engage smoothly without causing a jerky movement of the car, as is unavoidable with slipping bands. These linings are inexpensive and with ordinary good judgment a reverse and slow speed band should last at least 10,000 miles and the foot brake lining over 5,000 miles. Instructions for re-

moving the brake bands are given in the next chapter, the purpose of this paragraph being merely to explain the adjustments possible on the road.

Adjusting Loose Front Wheels.—At regular intervals while the car is in service it is important to examine the

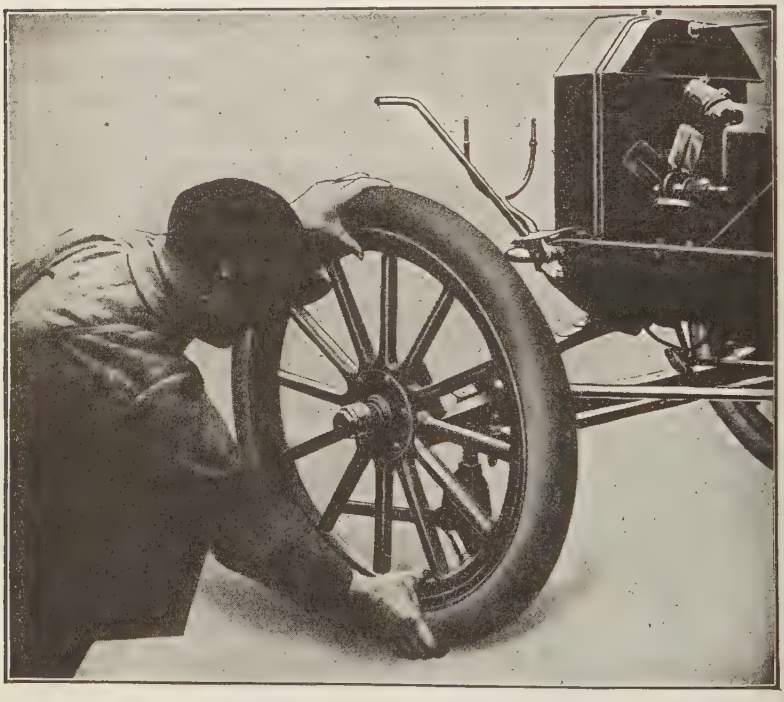

Fig. 62.—Testing for Front Wheel Looseness.

front wheels to make sure that these are retained properly by the front hub ball bearings. The method of testing the wheel for looseness is clearly shown at Fig. 62. The front axle is raised from the ground by jacks and the wheel is grasped at top and bottom by the operator, who

attempts to push the top of the wheel in and pull the bottom out, or the reverse of this operation. If the spindle is tight in the front axle yoke and there is considerable looseness in the wheel hub, the hub cap should be removed and the bearings carefully examined. The cone should be

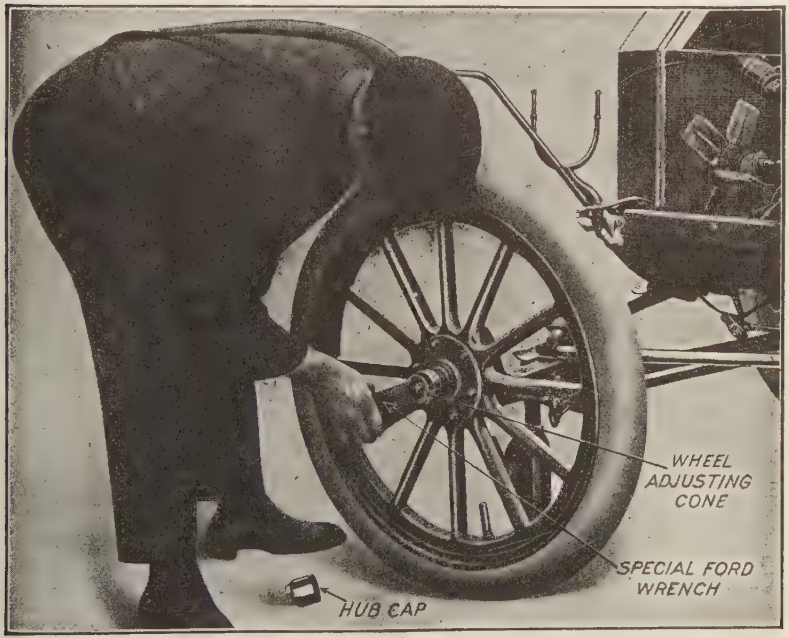

Fig. 63.—Showing Use of Special Ford Wrench in Adjusting Front Wheel Bearings.

removed from the spindle by pulling out the split pin that locks the castle nut, remove that member, as well as unscrewing the cone. After the cone is removed from the threaded end of the spindle the wheel may be readily withdrawn. The cones on both inner and outer parts of the spindle should be carefully examined to make sure that

they are not pitted or scored, and the balls and races in the wheels should also be examined for defects. If these parts are found in proper condition the proper wheel adjustment may be secured after the wheel is replaced by tightening on the wheel adjusting cone up to the point where the wheel will turn freely and have no appreciable end play. After the proper adjustment of the cone has been secured, the lock nut and split pin should be replaced. The hub cap should be filled with grease and replaced on the wheel hub. The interior construction of the Ford front wheel may be clearly understood by referring back to Fig. 32, which shows a sectional view of the Ford wheel hub and ball bearings in place.

What To Do When Rear Brakes Do Not Hold.—After the car has been in use for a time trouble may be experienced in holding it on a grade by locking the emergency brake hand lever. This is because the rear brake shoes have worn sufficiently so that they do not grip the brake drum interior in a positive manner. In some cases this wear may be taken up by shortening the rods running from the hand lever cross shaft to the brake cam levers. This may be done by the adjustment provided in threaded rod ends.

The method of testing the rear wheel brake is shown at Fig. 64. Two jacks are utilized to raise the rear axle to have both wheels clear of the ground. The hand brake lever is then applied and endeavor is made to move the wheel by grasping opposite spokes as shown, pushing down on one and pulling up on the other. If the wheel can be moved it is a sign that the brake shoes do not hold. It is possible to compensate for some wear of the brake shoes by shortening the rods, but it is important when this is done to have these of the same length in order that one brake will not take hold quicker than the other.

To examine the brakes it is necessary to remove the wheel, which is done by taking off the retention or clamping nut from the end of the axle and then applying a special wheel puller in place of the hub cap, as shown at Fig. 65. This wheel puller consists of a casting threaded to

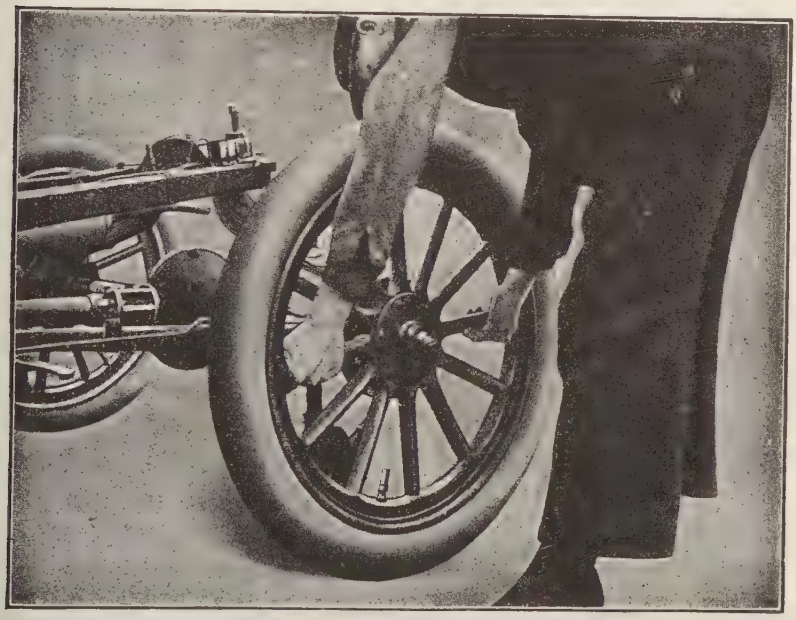

Fig. 64.—Method of Testing Rear Wheel Brakes, Also Wear in Axle Bearings.

fit the wheel hub at its lower end and carrying a set screw at the closed end. After the wheel puller body is properly screwed onto the hub and a clamp screw tightened to make sure that the puller body will not come off and strip the threads, the wheel may be forced off of the taper by screwing in on the set screw with a large monkey wrench furnished with the Ford tool outfit, at the same time keeping

the wheel puller body from turning with the hub cap wrench. If any difficulty is experienced in removing the wheel after a certain amount of tension is obtained by screwing in the set screw, a few sharp blows with a wooden

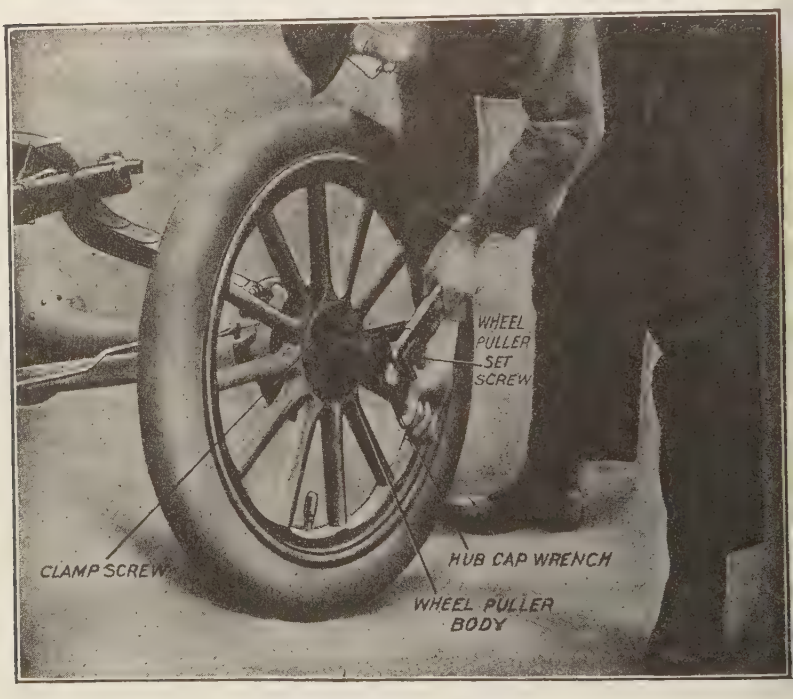

Fig. 65.—How to Use Wheel Puller for Removing Wheel From Taper Axle End.

mallet or lead hammer on the head of the set screw and applied in the direction of the axle will loosen the wheel.

After the wheel is removed the brake shoes may be readily examined as they are exposed, as shown at Fig. 66. It sometimes happens that the slipping is caused by oil deposits rather than wear. In this case the slipping is

easily remedied by cleaning out the interior of the brake drum and the faces of the brake shoes thoroughly with gasoline. If the shoes show signs of wear, which can be ascertained by noting if some portions are worn thinner than others, new brake shoes should be obtained and in-

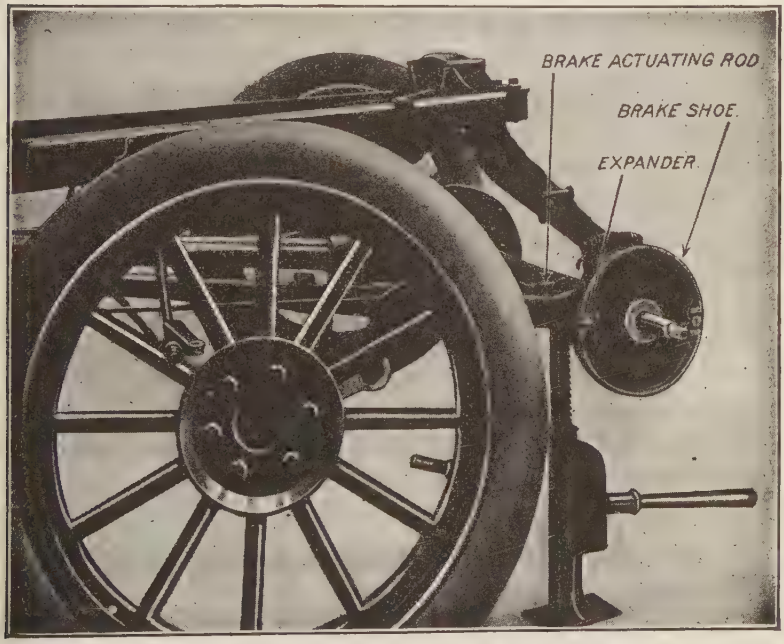

Fig. 66.—Wheel Removed to Show Internal Expanding Brake Construction.

stalled in place of the worn members. All that holds the brake shoe assembly is one retention bolt carried by the plate at the end of the axle. When this bolt is removed the brake shoe assembly can be pulled away from the axle and the expander cam. It is much cheaper to replace worn shoes with new ones, which are inexpensive, than to at-

tempt to get further service from the worn brake shoes by building upon the faces, which are in contact with the expander cam, as sometimes advised, or by attempting to apply a facing of sheet metal to the brake shoes. When new cast iron shoes are installed the wheel should be pushed on the axle taper and turned around with the hand brake lever in neutral position to make sure that there are no rough spots that will bear against the brake drums and cause friction, make a squeaking sound, and produce heating of the brakes when the car is running forward on the high speed. If any rough spots are found they should be smoothed off with a file. When reassembling the wheel care should be taken that the key used to drive the wheel is in place and that the hub is bedded tightly on the taper by the retaining nut, which must be screwed on tightly and locked with a split pin to prevent it backing off. If the brake shoes have been replaced after the actuating rods have been shortened several times it should be borne in mind that these rods must be lengthened again to normal length when new brake shoes are fitted.

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CHAPTER V

OVERHAULING AND REPAIRING MECHANISM

Faults in Power Plant and Symptoms—Value of System in Overhauling —How to Take Down Motor—Carbon Deposits and Their Removal—How to Repair Cracked Water Jacket—Reseating and Trueing Valves —Method of Valve Grinding—Inspection of Piston Rings—Piston Ring Manipulation—Fitting Piston Rings—Wrist Pin Wear—Inspection and Refitting of Engine Bearings—Knocking Indicates Loose Bearings—Adjusting Main Bearings—Scraping Bearings to Fit—Rebabbitting Connecting Rod—Testing Bearing Parallelism—Camshafts and Timing Gears—How to Time Valves in Ford Engines—Repairing Ford Magneto—Packings and Gaskets for Ford Engines—Precautions in Reassembling Parts—How to Take Down Transmission—Relining Brake Bands—Rear Axle Troubles and Remedies—Care of Springs—Steering Gear Repairs—Miscellaneous Chassis Parts.

After any automobile has been in use for a time, even if it has always been driven very carefully and oiled regularly according to the makers' instructions a certain amount of depreciation will exist in the mechanism and the car can only be put in good condition again by a thorough overhauling process. This is work for the skilled mechanic or owner with mechanical inclinations and a knowledge of the use of tools rather than the average owner or driver. The writer will endeavor to give sufficiently clear instructions however, so that the Ford owner who knows how to handle common tools and who has a general knowledge of common mechanical processes will be able to make many of the repairs mentioned in this chapter. To further facilitate an understanding of the descriptive matter photographs have been taken of numer-

ous parts of the Ford chassis mechanism in various stages of assembly and careful study of these will give even the non-mechanical owner some information that may be of value.

When a car needs overhauling it gives notice that this attention is needed by readily recognized symptoms. For example, the engine will lack its customary power and speed and hills that could formerly be negotiated on the high gear can be climbed only by the use of the low speed ratio. The engine will not accelerate properly nor run regularly and it will be noisy in action. The gears will grind all the time the machine is in use and the many minor chassis parts that have worn will rattle whenever the car is operated on anything but the best of highways. The brake bands in the transmission will have reached the limit of their adjustment, the brakes in the rear wheels will no longer hold positively when the hand lever is brought completely back in its travel. The car will not be as responsive to steering and considerable lost motion will be evidenced at the steering wheel which must be turned an appreciable amount in order to start to move the wheels. It will be apparent that while the car is still in an operative condition that it is not working efficiently. It is not desirable to run it when in need of mechanical repairs because the faulty parts are wearing more rapidly after initial depreciation sets in. The first point to consider will be the restoration of the mechanism of the power plant, after which the repair of the transmission and chassis parts will be discussed.

Faults in Power Plant and Symptoms.—There are a number of unmistakable symptoms that indicate depreciation of power plant components. The most common of these is lost power, then comes noisy operation. If an en-

gine loses power it is not always a sign that it is in need of a complete overhauling, as the trouble may be due to local causes which can be readily remedied without taking the engine out of the frame. If the lost power is accompanied by noisy action it is safe to consider that the trouble is due to wear of the motor parts. If an engine is cranked over by hand and the compression is poor, one may assume that either the valves need grinding or that the piston rings are worn or the cylinder walls scored. Back firing in the carburetor or inlet pipe, if it is not due to lean mixture, would be caused by leaky valves, the inlet valve not closing properly, defective inlet valve springs, or incorrect valve timing. If the engine has no power and the crank case gets hot, this is a sure indication of burned gas leakage past the piston rings which have become worn or broken. Noisy action in the engine, if not due to carbon deposits or insufficient lubrication would be the result of worn pistons and cylinder walls, worn wrist pin bushings in the piston bosses, loose connecting rod bearings at the crank shaft, loose main bearings, flywheel loose on crank shaft, camshaft driving gear loose on its retaining key, too much space between valve operating plungers and valve stem, or loose camshaft bearings. If the loss of power is accompanied by overheating and the cooling and lubricating systems are functioning properly, trouble is probably due to insufficient lift of the exhaust valves or the muffler may be clogged with carbon deposits, these preventing a free exhaust. The best way to overhaul the engine is to take it out of the frame and place it on a bench where it can be reached handily and the parts inspected more easily. Before describing the method of taking down the Ford motor, it may be well to consider the subject of systematic procedure in overhauling, as this is a

point that is often neglected by the professional repairmen as well as the amateur mechanic.

System in Overhauling.—Not a few motor car owners are backward in overhauling the motor, having in mind continually the fear that it will be a difficult matter to

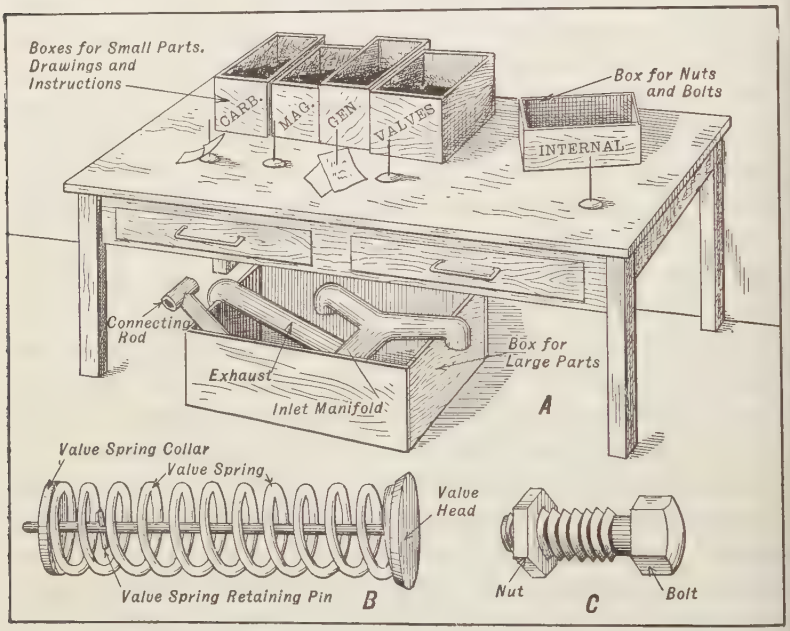


Fig. 67.—Showing Method of Providing Boxes for Keeping Parts Together in Overhauling Cars Systematically.

get the parts together again properly. While it is a comparatively simple procedure to remove parts it is quite the opposite in assembling so that the whole will be as it was originally. If a system is followed throughout there will be little if any trouble in resetting the motor parts or in fact any parts and for the benefit of the inexperienced owner a few hints on the subject that have appeared in

Motor Age are given here. Before anything is done to the motor the workbench should be put in shape. A number of boxes of varying sizes should be placed along the back of the bench as shown in Fig. 67. Each box is designed to receive the small parts of some unit such as the engine cylinder parts, valve system, etc., and each box should be properly marked with the name of the parts it is to contain. In front of each box a spindle file should be placed. These files are to be used for securing data sheets upon which are written notations concerning the various adjustments. Suppose difficulty should arise in removing a part, the first question to enter one's mind is "will it not be more difficult to return it to position?" Such a condition calls for a notation on a slip of paper and the exact location of all the parts drawn if necessary. In other words the files are used for memory so that the operator will know just how every part in each box was removed and the position it occupied with reference to some other object.

Adjustments often are required to be altered so that memory slips again are valuable in that the original adjustment can be jotted down. Aside from the small boxes on top of the bench a large box should be placed underneath. This is to care for large parts such as intake and exhaust manifolds, connecting rods, the fan, the carburetor and other parts of the assembly. In other words, the large box receives parts of which there is no doubt as to location. System in removing parts will eventually lead to a saving of time when assembly is necessary. For example when the valve system is removed, the valves, the springs, spring seats and the holding pins should be kept together as shown in illustration Fig. 67, B. In removing bolts, the lock washer, the nut and every part belonging to

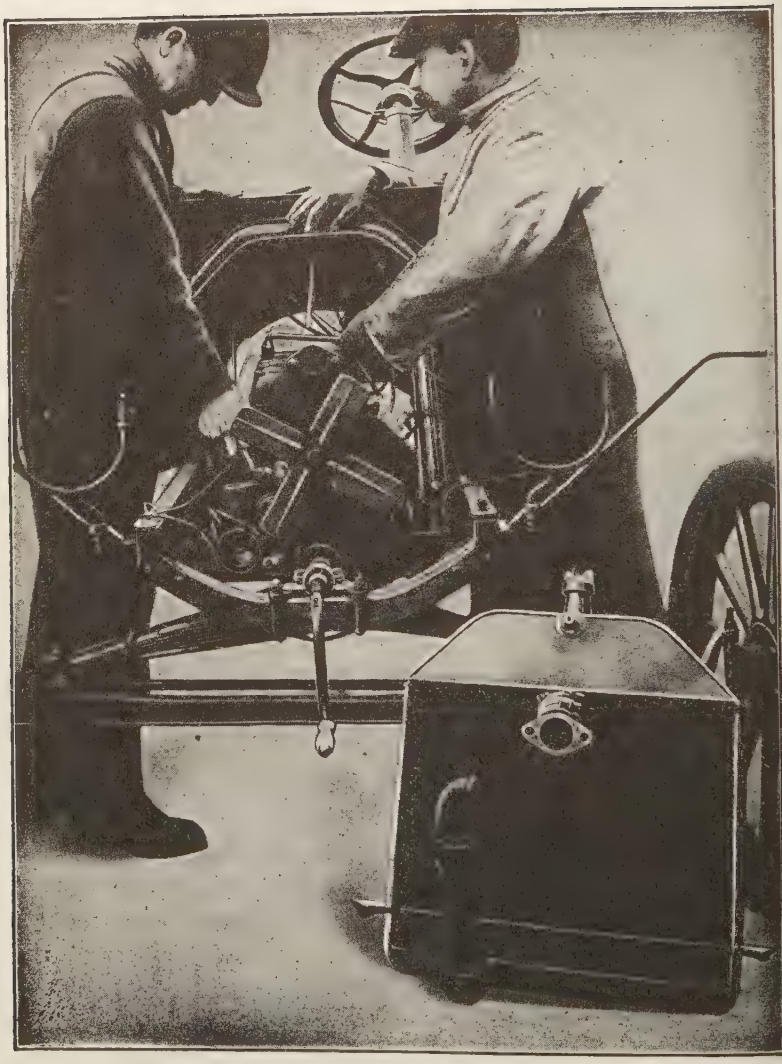


Fig. 68.—The First Step in Removing the Ford Engine From the Chassis Is to Take the Radiator From the Front of the Frame.

the bolt should be kept together as at Fig. 67, C. Slip the washer over the bolt and screw the nut in place and then throw the whole into the proper box. When the wrist pins are removed the clamp screw for holding the pin in place should be left in the hole in the connecting rod boss. When the manifolds are removed, instead of throwing the holding nuts into one box and the manifold in another, screw the nuts back onto the studs in the cylinder. The object of all this immediate replacement is to keep the parts as near to their proper places as possible so that when assembly begins the operator will not be in doubt as to where to look for a certain rod bolt or other part.

How To Take Down Motor.—The first step in removing the Ford engine from the frame is to drain the water from the radiator by opening the petcock at the bottom and while the water is draining out to disconnect the spark plug wires at the top of the motor. After the water is drained out the water connections are unfastened from the top of the motor and the side of the water jacket leaving the hose and water pipes attached to the radiator as clearly shown in Fig. 68. The next step is to disconnect the radiator brace rod which holds it to the dash by unscrewing it out of the lug at the top of the radiator. In order to unscrew this rod it will be necessary to loosen the check nut on the end of the rod that bears against the dash. The two nuts that fasten the radiator to the frame are removed and the radiator may be taken off and placed to one side of the way, care being taken to place it in a position where it will not be injured by tools or other parts falling on the cooling tubes.

Next disconnect the dash at the two supporting brackets which rest on the frame and detach the steering post guide bracket carried at the left hand side of the

frame. The timer case or cover is loosened by releasing the retaining clamp spring as shown in illustration and the circular loom containing the four timer wires running to the coil is released from the small clamp that holds it to the frame member in some cases. This makes it possible to remove the steering post, dash, and all the wiring as one assembly. Before taking off the steering post and dash assembly it is necessary to disconnect the carburetor control, mixture adjustment and timer cover advance rods. Then the two bolts of the cap holding the ball at the apex of the triangular front radius rod member are unscrewed from the socket underneath the crank case. The next step is to free the rear of the engine from the rear axle unit, which is done by removing four bolts at the universal joint ball housing. The next step is to turn off the gasoline at the tank, disconnect the fuel supply pipe from the carburetor, and remove the pressed steel pans joining the cylinder casting to the frame on each side. The exhaust manifold is uncoupled from the exhaust pipe by unscrewing the large brass packing nut. Next release the cap of the trunnion bearing which supports the front end of the crank case on the front frame cross member which is done by unscrewing the two cap screws that hold the cap in place. The crank case supporting arms are attached to the frame side members by two bolts in each arm. These bolts should be removed which breaks the last connection holding the motor to the frame.

A stout rope is passed through the opening between the two middle cylinders and is tied with some form of positive holding but quick releasing knot. A piece of 2″ x 4″ studding or a substantial iron pipe about 10 feet long is passed through the rope. The engine may be lifted out of the frame by three men, one at each end of the beam or

pipe while the third man takes hold of the starting crank handle to steady the power plant while it is being lifted. If a chain falls or portable crane is available one man may easily handle the power plant.

After the engine is removed the first step in taking it down is to release the fifteen cap screws which hold the

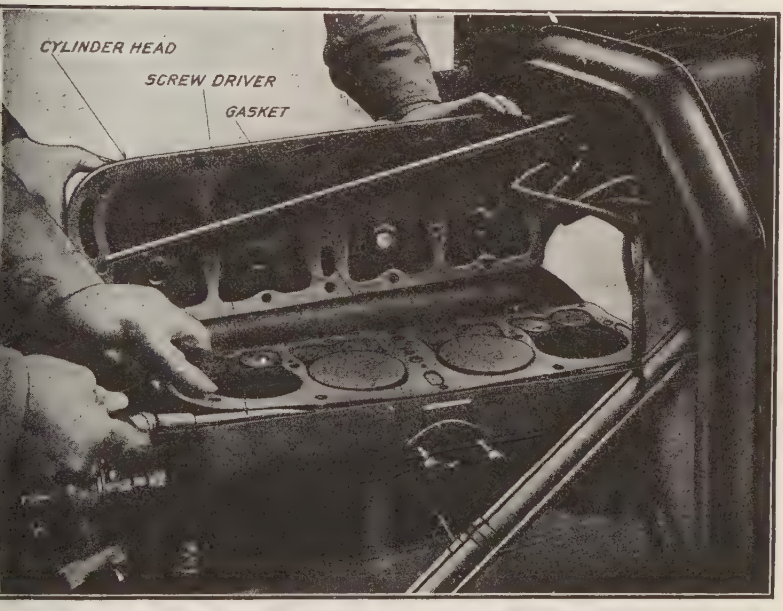


Fig. 69.—Showing Method of Removing Copper Asbestos Gasket Used Between Cylinder Head and Cylinder Block Casting of the Ford Engine.

cylinder head in place and take the head casting off. Next the bottom plate on the crank case is removed and all the connecting rods loosened up which permits of pushing the pistons out through the top of the cylinder if desired. The cooling fan and the fan belt are removed and placed with the radiator where they will be out of the way. At

Fig. 68 the dash assembly is just loose enough to be raised from the frame when necessary and one of the workmen is loosening the cylinder head retention bolts before the engine is lifted out of the frame on account of the superior purchase or grip afforded when the engine is in place. The workman at the right is loosening the fan bracket adjusting bolt in order to take off the fan.

After the cylinder head is removed the next operation is to carefully take off the gasket which will be found on top of the cylinder casting. This is done by prying it away from the cylinder block gradually with a screw driver or other similar implement. The next step is to remove the inlet and exhaust manifolds which is done by unloosening the stirrups or clamps holding these in place as shown at Fig. 70. This exposes the valve chamber covers which may be removed as outlined at Fig. 71. The method of taking the piston out through the top of the cylinder head after the connecting rod cap has been removed from the crank shaft is clearly shown at Fig. 72. The top half of the transmission case is then lifted off, which can only be done after the brake band adjustments have been loosened up and a number of retention bolts removed. The final operation is to take off the pressed steel lower crank case member which also forms the lower portion of the transmission case compartment. The appearance of the bottom of the engine after this is done is clearly shown at Fig. 73.

It is important to keep all parts that come from any special member together and mark them so that they may be readily identified. Many experienced repairmen have the habit of throwing all parts in a common box and then picking them out as needed. While the expert has no difficulty in distinguishing the pieces much time is lost

in looking for the various bolts and nuts, to say the least, while if the novice follows this practice he will be hopelessly confused and will have difficulty in identifying the various pieces. If the pistons and connecting rods are not already marked they should be plainly stamped with steel

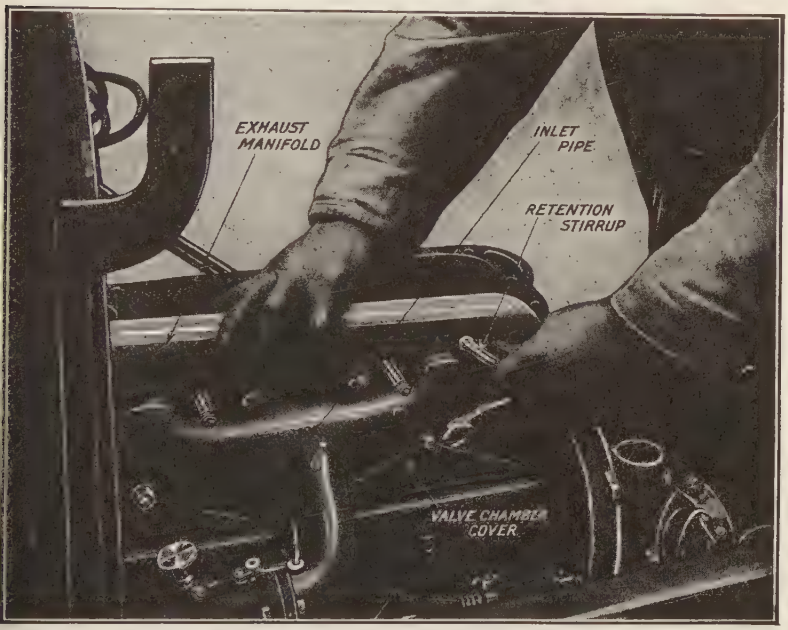


Fig. 70.—Method of Removing Inlet and Exhaust Manifold.

numbers or letters or with a series of prick punch marks to make sure that they will be replaced in the same cylinder from which they were removed.

Carbon Deposits and Their Removal.—Mention has been previously made that carbon deposits in the combustion chamber are not desirable because they are apt to produce overheating and noisy operation and result in diminution of power. The knock produced by carbon is a clear hollow

sound, generally evidenced when climbing grades on the high speed, especially after the engine has become heated. Carbon deposits are also indicated by a sharp knock noticed whenever the engine is speeded up by opening the throttle. The knock produced by having the spark too

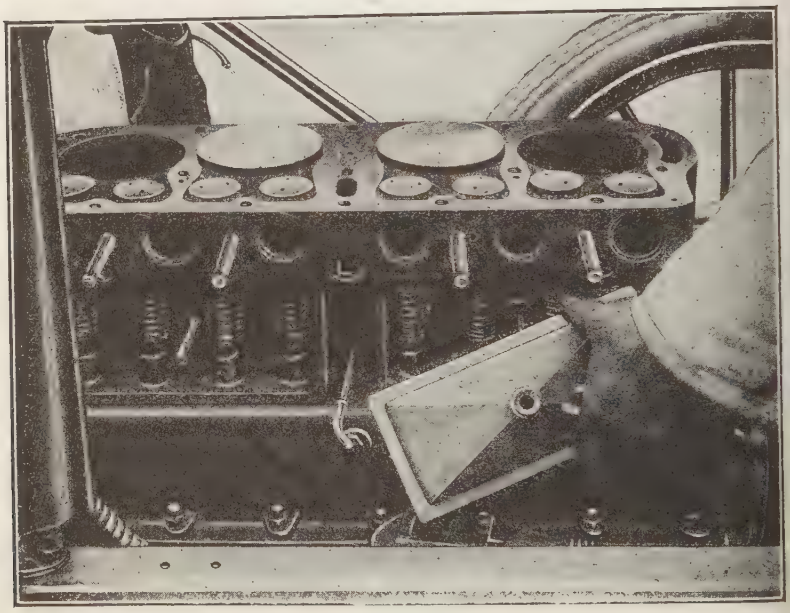


Fig. 71.—Valve Chamber Cover Plates Must Be Removed to Gain Access to the Valve Springs.

far advanced is duller than that which is caused by carbon. A loose connecting rod knock sounds like the tapping of steel with a small hammer and is most easily distinguished when a car is allowed to coast down grade or upon suddenly slowing up the car from speeds of 25 to 30 miles an hour by closing the throttle. Looseness in the crank shaft main bearings produces a knock which can be best

distinguished when the car is going up hill or under road conditions where the engine is working hard. The knocking sound produced by a loose piston is heard when the throttle is suddenly opened and is almost exactly the same as a carbon knock.

It is not necessary to take the engine entirely out of

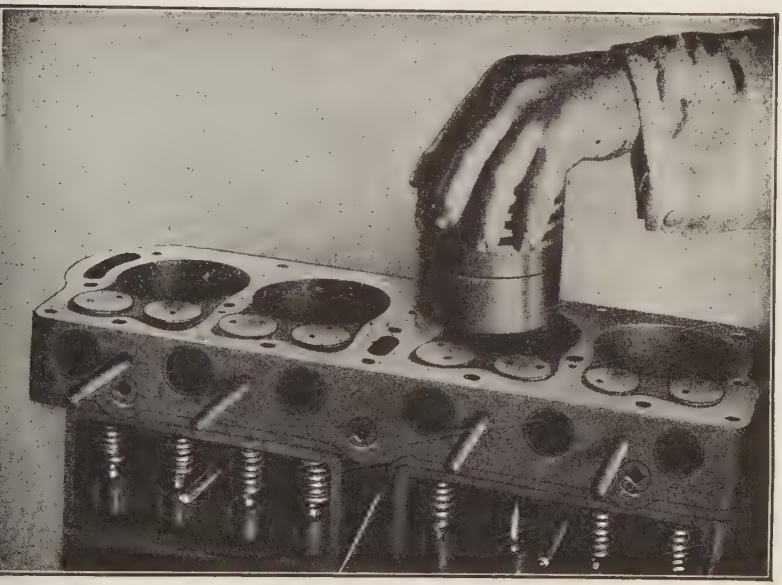


Fig. 72.—How Ford Piston May Be Withdrawn Through Top of Motor.

the frame only to remove carbon or grind valves, though if these two processes are to be done at the same time the motor is overhauled it will be just as well to do all that is necessary to the engine after it has been taken out of the frame. If one desires merely to remove carbon, the first step is to drain the water out of the radiator and to disconnect the water connection bolts at the cylinder head.

The wires should be disconnected from the spark plugs in the cylinder head and these should be removed in order that they may be cleaned and placed out of harm's way. If the spark plugs are left in the cylinder and a wrench is applied to a cylinder head bolt and slips off, one is very likely to break the insulation of the spark plug which is of porcelain, a very brittle material. It is not necessary to remove the radiator when the cylinder head is taken off

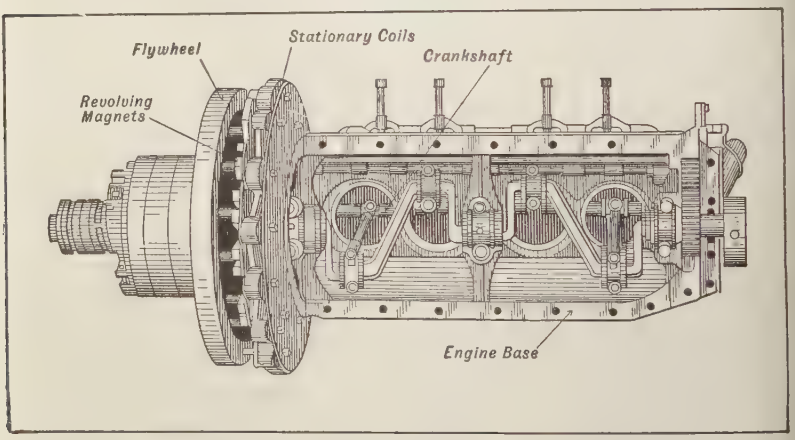


Fig. 73.—Bottom View of Ford Engine With Pressed Steel Lower Crank Case Member Removed.

for scraping carbon from the piston tops or grinding valves.

After the cylinder head has been removed it should be inverted on the work bench and the spark plug holes plugged up by screwing in the plugs. The combustion chambers are then filled with kerosene which is allowed to soak in to soften the carbon deposits while those on the piston top are scraped off with a putty knife, as shown at Fig. 74. Care should be taken to prevent the particles of

carbon from getting into the cylinders, bolt holes or water jacket openings. It is evident that the gasket must be removed from the cylinder block as shown at Fig. 69 before the carbon is scraped away. If the carbon removal process is to be followed by valve grinding it will be well

Fig. 74.—Method of Removing Carbon Deposits from Piston Top and Cylinder Block.

to take off the inlet and exhaust manifolds as shown at Fig. 70 and the valve chamber cover plates as outlined at Fig. 71. Care should be taken in replacing the cylinder head gaskets to have the pistons in the cylinders No. 1 and No. 4 at top center, using these as guide members to locate the gasket in position and to locate the cylinder head in place.

Be sure to draw the cylinder head retaining bolts down evenly, turning down each one only a few turns at a time. Do not tighten the bolts at one end before the other, but all should be given the final turn to bed them down at practically the same time. The best way is to turn those in the center of the casting down so they bed loosely first, then to tighten one at the front and one at the rear. After this all of the bolts may be screwed down tightly. After the cylinder head is replaced the engine crank shaft should be turned over with the starting handle so as to be sure that the gasket does not project over the cylinder bore, which would mean that the piston would hit it when it came to the top of the stroke. Before replacing the cylinder head the combustion chamber should be thoroughly cleaned out and all carbon removed by scraping. If the kerosene has been used as recommended, in many cases the carbon deposits may be softened sufficiently so they may be wiped out with a rag.

How to Repair Cracked Water Jacket.—The water jacket of the Ford engine cylinder will sometimes become cracked due to freezing of the cooling water or perhaps as a result of a sand or blow hole which opens up from vibration after the cylinder has been used awhile. At the present time the usual practice in repairing cylinders is to fill the depression or crack with iron by the autogenous welding process, although various iron cements may be used for that purpose if the fracture is not serious. A mechanical repair is always possible, i.e., a metal patch can be applied to cover the crack and held in place against a gasket interposed between the plate and the cylinder jacket by small machine screws tapped into the iron.

If the crack is of some length it may be repaired by the following method: On the line of the fracture, drill

and tap for a ⅜″ threaded copper rod. This rod is screwed in firmly to a depth about equal to the thickness of the metal of the water jacket. Cut off the copper rod with a hacksaw, allowing it to project about 1/32″; then drill succeeding holes, each hole being drilled partly into the previously inserted copper plug, so that when all of the plugs are placed in the cylinder casting, they form a continuous band of copper along the line of the fracture. The copper plugs should be peened down and trimmed off flush. The only possible chance for leakage, after having repaired the crack in this manner, is for the water to follow the joint between the metal of the jacket and the copper plugs, but as the copper rods are threaded into the casting, it is not likely to occur. Should leakage take place, a little extra peening will suffice to prevent it.

Still another method involves fusing copper filings or granulated brass spelter into the crack. This has the advantage of not requiring the removal of the part to be repaired. Drill and tap a small hole at each end of the crack to prevent further extension of the weakness, and screw in an iron stud. Next clean the outside and inside of the fracture very thoroughly, using a scraper and gasoline. File up some soft copper or brass spelter, mix with borax and fill the crack, heaping the filings over it. Then take a powerful blow lamp or a torch and direct the flame on the copper. By this method a fair amount of metal can be worked into the opening. After cooling, the studs are cut off flush and the copper filed smooth. It is said that the repair will endure indefinitely.

In many cases where the crack is not serious it may be closed by making a rust joint. The first step is to drill a very small hole at each end of the crack to prevent it from spreading and to drive in or screw in a metal plug in each

hole. The crack is then filled up with a paste made of 66% iron filings or iron dust and 33% sal ammoniac in the pulverized form, with just enough water to make the mixture of proper consistency to be pressed into the crack easily. The action of the sal ammoniac is to rapidly oxidize the fine iron filings, producing rust which joins the various iron particles together and effectively seals the opening when it has properly hardened. As a number of prepared cements for use with cast iron may be purchased at low cost it is often cheaper to buy the cement than to attempt to make it.

Another method sometimes employed is to clean out the interior of the water jacket thoroughly and put in a solution of sulphate of copper or bluestone, allowing this to leak through the crack, if it will. Care is taken to remove any traces of grease that may remain in the crack; this may be washed out by a boiling hot solution of potash or caustic soda. As the copper sulphate solution leaks out, it deposits a thin copper film, and if the crack is such that it permits only a slow leak, the defective point will be sealed overnight with a deposit of pure copper.

Reseating and Truing Valves.—Much has been said relative to valve grinding and despite the mass of information given in the trade prints it is rather amusing to watch the average repair man or the motorist who prides himself on maintaining his own car performing this essential operation. The common mistakes are attempting to seat a badly grooved or pitted valve on an equally bad seat, which is an almost hopeless job, and of using coarse emery and bearing down with all one's weight on the grinding tool with the hope of quickly wearing away the rough surfaces. The use of improper abrasive material is a fertile cause of failure to obtain a satisfactory seating.

Valve grinding is not a difficult operation if certain precautions are taken before undertaking the work. The most important of these is to ascertain if the valve head or seat is badly scored or pitted. If such is found to be the case no ordinary amount of grinding will serve to restore the surfaces. In this event the best thing to do is to remove the valve from its seating and to smooth down both

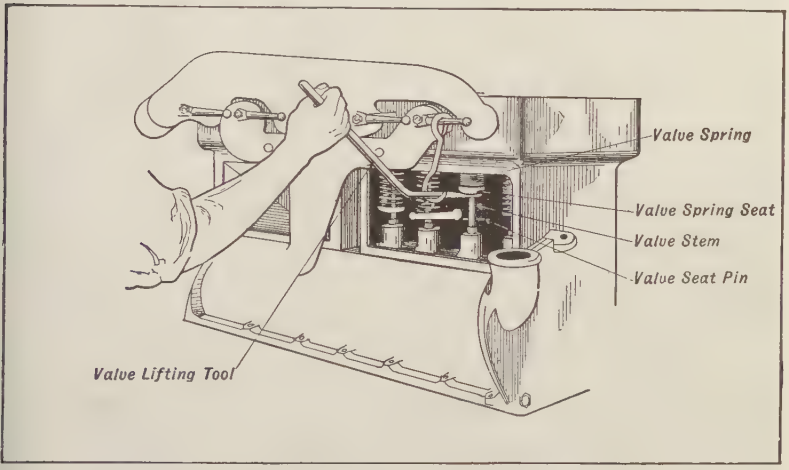


Fig. 75.—Method of Compressing Valve Spring in Order to Remove Valve Seat Pin by Using Ford Valve Spring Lifter.

the valve head and the seat in the cylinder before attempt is made to fit them together by grinding. Another important precaution is to make sure that the valve stem is straight, and that the head is not warped out of shape.

A number of simple tools are available at the present time for truing valve seats, one of these being outlined in use at Fig. 77. It is a simple reamer having cutters conforming to the valve seat angle and a T-handle by which it may be turned.

Method of Valve Grinding.—The process of seating

valves by grinding is not a difficult one, requiring patience more than mechanical skill. The first step is to remove the valves, which may be accomplished as shown at Fig. 75, using the regular Ford tool, or at Fig. 76, using another type of valve spring compressor. Before the valves can

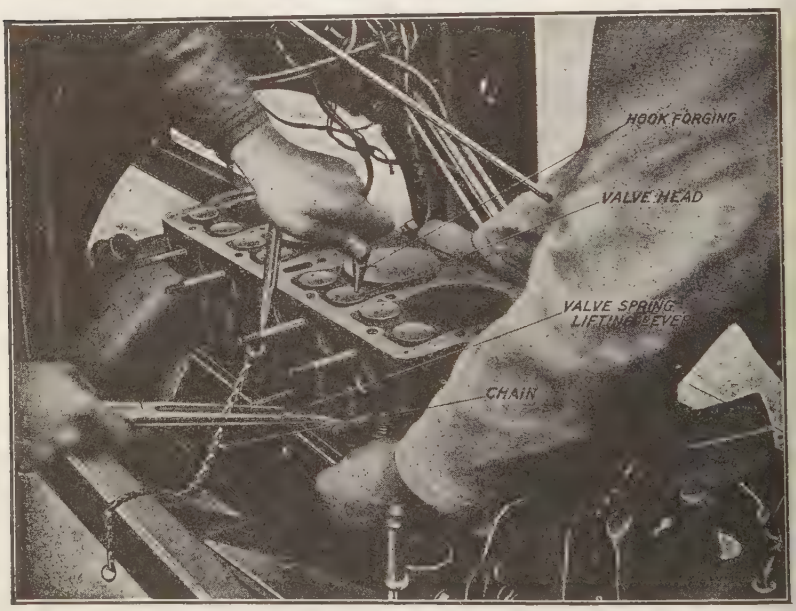


Fig. 76.—Special Tool for Raising Valve Springs When Inlet and Exhaust Manifolds are Taken Off of the Cylinder Block.

be removed, the spring that keeps them seated must be raised enough to permit the removal of the valve seat pin shown at Fig. 75. After the pin is pulled out of the valve stem, the valve may be pushed up from its seat and removed for examination. The writer believes that it is better to remove the manifolds before grinding the valves, so the tool shown at Fig. 76 is best to raise the

valve spring as it does not depend upon a manifold retaining stirrup as an anchorage. Another advantage is that it keeps the valve head against the seat while the spring is compressed.

A special bit stock arrangement made especially for

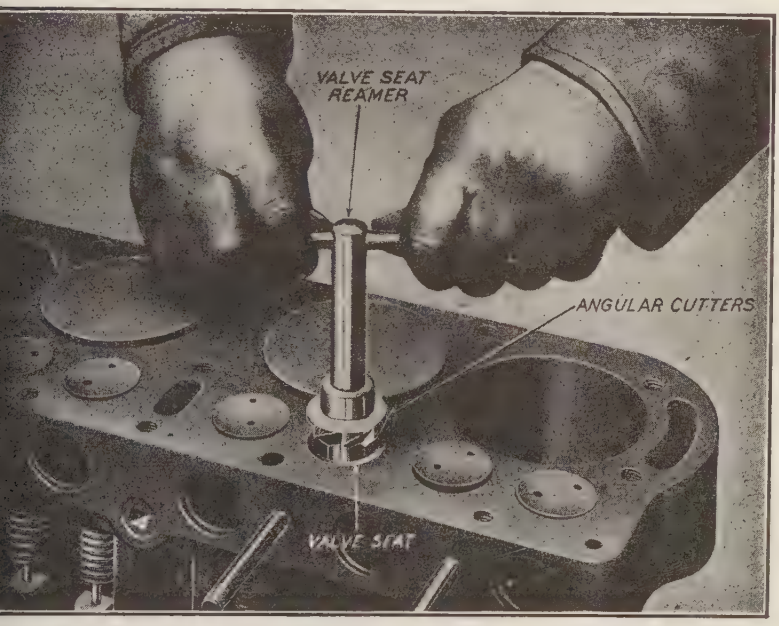


Fig. 77.—Showing Use of Valve Seat Reamer for Smoothing Scored or Pitted Valve Seats.

grinding in Ford valves is shown in use at Fig. 78. The lower portion of the valve grinding tool has two pins to engage the corresponding holes in the valve head. An abrasive paste is placed between the valve head and seat and the valve is turned or oscillated so the cutting material removes the roughness from the valve seat and valve, fitting one to the other. It is advisable to lift the valve

from its seat frequently as the grinding operation continues, this is to provide an even distribution of the abrasive material placed between the valve head and its seat. Only sufficient pressure is given to the bit stock to overcome the uplift of the spring beneath the valve and to

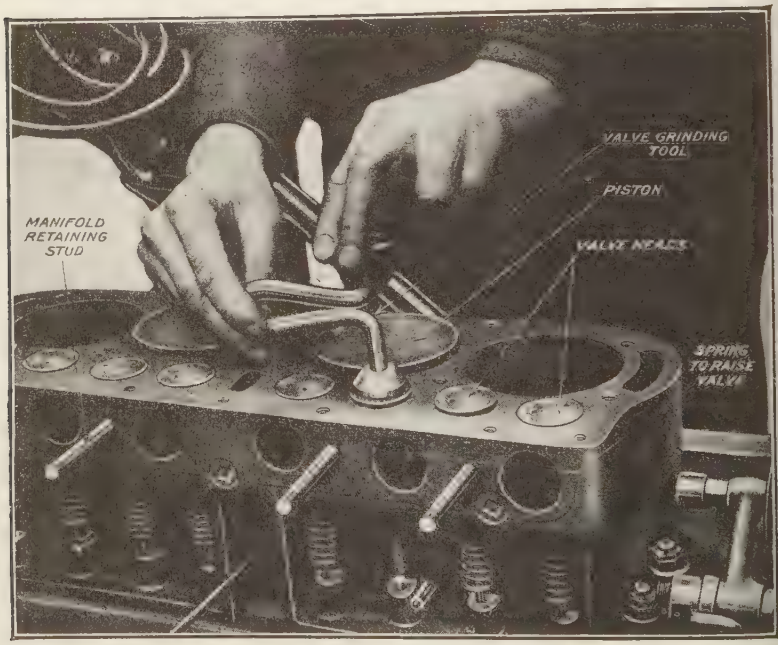


Fig. 78.—Showing Use of Special Tool for Grinding Ford Valves.

insure that the valve will be held against the seat. Where the spring is not used it is possible to lift the valve from time to time with the hand, which is placed under the valve stem to raise it as the grinding is carried on. It is not always possible to lift the valve in this manner when the cylinders are in place on the engine base owing to the space between the valve lift plunger and the end of

the valve stem. In this event, the use of the spring as shown in Fig. 78, where it is discernible through the gas port will be desirable to raise the valve head when the grinding tool is lifted and the pressure released.

The abrasive generally used is a paste made of medium or fine emery and lard oil or kerosene. This is used until the surfaces are comparatively smooth, after which the final polish or finish is given with a paste of flour emery, grindstone dust, crocus, or ground glass and oil. An erroneous impression prevails in some quarters that the valve head surface and the seating must have a mirror-like polish. While this is not necessary it is essential that the seat in the cylinder and the bevel surface of the head be smooth and free from pits or scratches at the completion of the operation. All traces of the emery and oil should be thoroughly washed out of the valve chamber with gasoline before the valve mechanism is assembled, and in fact it is advisable to remove the old grinding compound at regular intervals, wash the seat thoroughly and supply fresh materials from time to time as the process is in progress. The truth of seatings may be tested by taking some Prussian blue pigment and spreading a thin film of it over the valve seat. The valve is dropped in place and is given about one-eighth turn with a little pressure on the tool. If the seating is good both valve head and seat will be covered uniformly with color. If high spots exist, the heavy deposit of color will show these while the low spots will be made evident because of the lack of pigment. The grinding process should be continued until the test shows an even bearing of the valve head at all points of the cylinder seating.

Inspection of Piston Rings.—The piston rings should be taken out of the piston grooves and all carbon deposits

removed from the inside of the ring and the bottom of the groove. It is important to take this deposit out because it prevents the rings from performing their proper functions by reducing the ring elasticity, and if the deposit is allowed to accumulate it may eventually result in sticking and binding of the ring, this producing excessive friction or loss of compression. When the rings are removed they should be tested to see if they retain their elasticity. If gas has been blowing by the rings or if these members have not been fitting the cylinder properly the points where the gas passed will be evidenced by a burnt, brown or roughened portion of the polished surface of the pistons and rings. The point where this discoloration will be noticed more often is at the thin end of an eccentric ring, the discoloration being present for about ½″ or ¾″ each side of the slot. It may be possible that the rings were not true when first put in. This made it possible for the gas to leak by in a small amount initially which increased due to continued pressure until quite a large area for gas escape had been created.

Piston Ring Manipulation.—Removing piston rings is a difficult operation if the proper means are not taken but is a simple one when the trick is known. The tools required are very simple, being three strips of thin steel about one-quarter inch wide and four or five inches long and a pair of spreading tongs made up of one-quarter inch diameter keystock tied in the center with a copper wire to form a hinge. The construction is such that when the hand is closed and the handles brought together the other end of the expander spreads out, an action just opposite to that of the conventional pliers. The method of using the tongs and the metal strips is clearly indicated at Fig. 79. At A the ring expander is shown spreading the ends of the

rings sufficiently to insert the pieces of sheet metal between one of the rings and the piston. Grasp the ring as shown at B, pressing it off with the thumbs on the top of the piston and the ring will slide off easily, the thin metal strips acting as guide members to prevent the ring from catching in the other piston grooves. Usually no difficulty

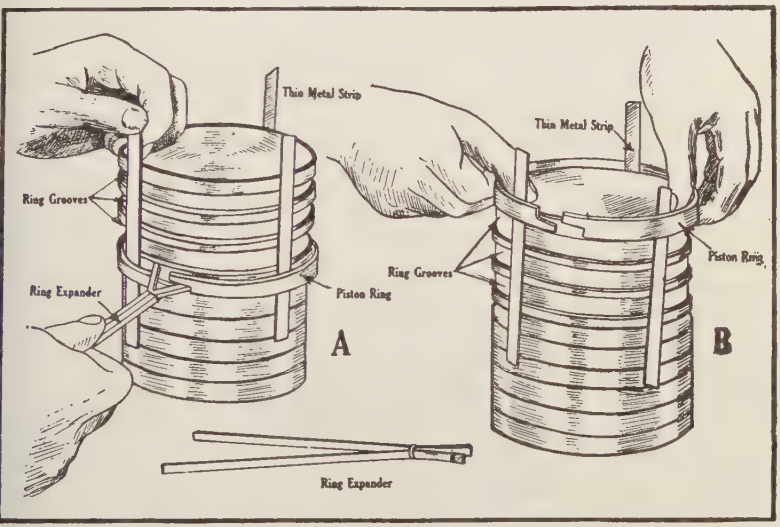


Fig. 79.—Showing Method of Removing Piston Rings Without Damaging Them.

is experienced in removing the top or bottom rings as these members may be easily expanded and worked off directly without the use of a metal strip. When removing the intermediate rings, however, the metal strips will be found very useful. These are usually made by the repairman by grinding the teeth from old hacksaw blades and rounding the edges and corners in order to reduce the liability of cutting the fingers. By the use of the three

metal strips a ring is removed without breaking or distorting it and practically no time is consumed in the operation.

Fitting Piston Rings.—Before installing new rings, they should be carefully fitted to the grooves to which they are applied. The tools required are a large piece of fine emery cloth, a thin flat file, a small vise with copper or leaden jaw clips and a hard smooth surface such as that afforded by the top of a surface plate or a well planed piece of hard wood. After making sure that all deposits of burnt oil and carbon have been removed from the piston grooves, three rings are selected, one for each groove. The ring is turned all around its circumference into the groove it is to fit which can be done without springing it over the piston as the outside edge of the ring may be used to test the width of the groove just as well as the inside edge. The ring should be a fair fit and while free to move circumferentially there should be no appreciable up and down motion. If rings are a tight fit, each should be laid edge down upon the piece of emery cloth which is placed on the surface plate and carefully rubbed down until it fits the groove it is to occupy. It is advisable to fit each piston ring individually and to mark them in some way to insure that they will be placed in the groove to which they are fitted.

The repairman next turns his attention to fitting the ring in the cylinder itself. The ring should be pushed into the cylinder at least two inches up from the bottom and endeavor should be made to have the lower edge of the ring parallel with the bottom of the cylinder. If the ring is not of correct diameter but is slightly larger than the cylinder bore, this condition will be evident by the angular slots of the rings being out of line or by difficulty in in-

serting the ring if it is a lap joint form. If such is the case the ring is removed from the cylinder and placed in the vise between soft metal jaw clips. Sufficient metal is removed with a fine file from the edges of the ring at the slot until the edges come into line and a slight space exists between them when the ring is placed in the cylinder. It is important that this space be left between the ends for if this is not done when the ring becomes heated the expansion of metal may cause the ends to abut and the ring to jam in the cylinder.

It is necessary to use more than ordinary caution in replacing the rings on the piston because they are usually made of cast iron, a metal that is very fragile and liable to break because of its brittleness. Special care should be taken in replacing new rings as these members are more apt to break than old ones. This is probably accounted for by heating action on used rings which tends to anneal the metal as well as making it less springy. The bottom ring should be placed in position first, which is easily accomplished by springing the ring open enough to pass on the piston and then sliding it into place in the lower groove which on some types of engines is below the wrist pin whereas in others all grooves are above that member. The other members are put in by a reversal of the process outlined at Fig. 79. It is not always necessary to use the guiding strips of metal when replacing rings as it is often possible, by putting the rings on the piston a little askew and manuvering them to pass the grooves without springing the ring into them. The top ring should be the last one placed in position.

Before replacing pistons in the cylinder one should make sure that the slots in the piston rings are spaced equidistant on the piston. The slots should never be in

line, especially with diagonal cut rings. The cylinder should be well oiled before attempt is made to install the pistons. The engine should be run with more than the ordinary amount of lubricant for several days after new piston rings have been inserted. On first starting the engine, one may be disappointed in that the compression is even less than that obtained with the old rings. This condition will soon become remedied as the rings become polished and adapt themselves to the contour of the cylinder. It will take fully 100 miles of road work to bring the rings to a sufficiently good fit so that a marked improvement in compression will be noticed.

Wrist Pin Wear.—While wrist pins are usually made of very tough steel, case-hardened, with the object of wearing out an easily renewable bronze bushing in the piston bosses rather than the wrist pin, it sometimes happens that these members will be worn so that even the replacement of new bushings in the piston will not reduce the lost motion and attendant noise due to a loose wrist pin. The only remedy is to fit new wrist pins to the piston. Where the connecting rod is clamped to the wrist pin and that member oscillates in the piston bosses the wear will usually be indicated on bronze bushings which are pressed into the piston bosses. These are easily renewed and after running a reamer of the proper size through them no difficulty should be experienced in replacing either the old or a new wrist pin depending upon the condition of that member.

Inspection and Refitting of Engine Bearings.—While the engine is dismantled one has an excellent opportunity to examine the various bearing points in the engine crank case to ascertain if any looseness exists due to depreciation of the bearing surfaces. As will be evident from Fig.

73 the three main crank shaft bearings and the lower ends of the connecting rods may be easily examined for deterioration when the crank case lower half is removed. With the rods in place as shown it is not difficult to feel the amount of lost motion by grasping the connecting rod firmly with the hand and attempting to move it up and

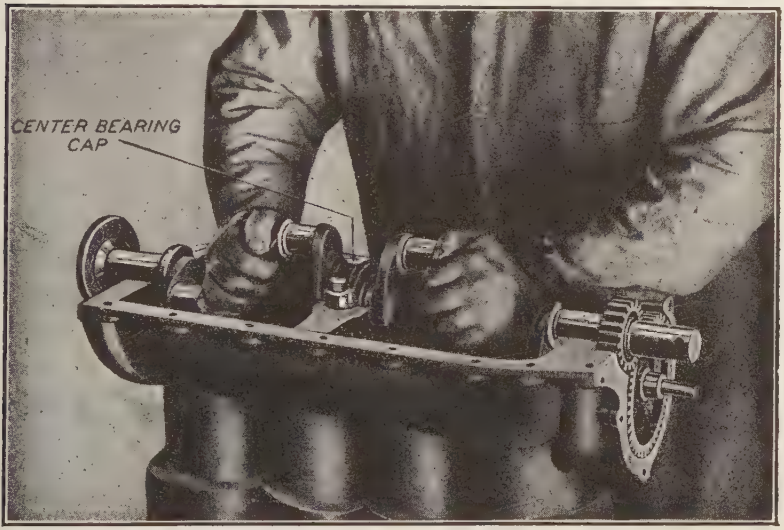


Fig. 80.—Showing Method of Testing Main Bearings When Refitting by Rocking the Crank Shaft by Hand.

down. The appearance of the engine base after the connecting rods and flywheel have been removed from the crank shaft is shown at Fig. 80, while the appearance of the inverted upper portion of the crank case after the crank shaft is removed is clearly shown at Fig. 81. In this view the cylinder block is supported head end down on the bench.

After the connecting rods have been removed and the

flywheel taken off the crank shaft to permit of ready handling, any looseness in the main bearing may be detected by lifting up either the front or rear end of the crank shaft with a pinch bar and observing if there is any lost motion between the shaft journal and the main bearing caps. It is not necessary to take an engine entirely apart to examine the main bearings, as in the Ford engine these may be readily reached by removing a large inspection plate from the bottom of the engine crank case. This may be done without taking the engine out of the frame, though if bearings are worn to any extent much time will be saved by having the engine base on a bench where it can be reached easily, and worked on with some degree of comfort.

"Knocking" Indicates Loose Bearings.—If an engine knocks when a vehicle is traveling over level roads regardless of speed or spark lever position and the trouble is not due to carbon deposits in the combustion chamber one may reasonably surmise that the main bearings have become loose or that lost motion may exist at the connecting rod big ends and possibly at the wrist pins. The main journals of the Ford engine are proportioned with ample surface and will not wear unduly unless lubrication has been neglected. The connecting rod bearings wear quicker than the main bearings owing to being subjected to a greater unit stress and it may be necessary to take these up several times in a season if the car is driven to any extent. Main bearings should run for ten thousand miles without attention in a properly built engine that has always been well oiled. Most connecting rod bearings will loosen up enough to be taken up in five thousand miles.

Adjusting Main Bearings.—When the bearings are not

worn enough to require refitting the lost motion can often be eliminated by removing one or more of the thin shims or liners ordinarily used to separate the bearing caps from the seat. Care must be taken that an even number of shims of the same thickness are removed from each side of the journal. If there is considerable lost motion after one or two shims have been removed it will be advisable to file some metal from the bearing cap and to scrape the bearing to a fit before the bearing cap is finally tightened up.

The following instructions for refitting main bearings are given by the Ford Motor Company in their book of instructions:

(1) After the engine has been taken out of the car, remove crank case, transmission cover, cylinder head, pistons, connecting rods, transmission and magneto coils. Take off the three babbitted caps and clean the bearing surfaces with gasoline. Apply blue or red lead to the crank shaft bearing surfaces, which will enable you, in fitting the caps, to determine whether a perfect bearing surface is obtained.

(2) Place the rear cap in position and tighten it up as much as possible without stripping the bolt threads. When the bearing has been properly fitted, the crank shaft will permit moving with one hand. If the crank shaft cannot be turned with one hand, the contact between the bearing surfaces is evidently too close, and the cap requires shimming up, one or two brass liners usually being sufficient. In case the crank shaft moves too easily with one hand, the shims should be removed and the steel surface of the cap filed off, permitting it to set closer.

(3) After removing the cap, observe whether the blue or red "spottings" indicate a full bearing the length of

the cap. If "spottings" do not show a true bearing, the babbitt should be scraped and the cap refitted until the proper results are obtained.

(4) Lay the rear cap aside and proceed to adjust the center bearing in the same manner. Repeat the operation with the front bearing, with the other two bearings laid aside.

(5) When the proper adjustment of each bearing has been obtained, clean the babbitt surface carefully and place a little lubricating oil on the bearings, also on the crank shaft; then draw the caps up as closely as possible —the necessary shims, of course, being in place. Do not be afraid of getting the cap bolts too tight, as the shim under the cap and the oil between the bearing surfaces will prevent the metal being drawn into too close contact. If oil is not put on the bearing surfaces, the babbitt is apt to cut out when the motor is started up before the oil in the crank case can get into the bearing.

In replacing the crank case and transmission cover on the motor, it is advisable to use a new set of felt gaskets to prevent oil leaks.

Scraping Brasses To Fit.—To insure that the bearing brasses will be a good fit on the crank pins or crank shaft journals they must be scraped to fit. The process of scraping, while a tedious one, is not difficult, requiring only patience and some degree of care to do a good job. The crank pin surface is smeared with Prussian blue pigment which is spread evenly over the entire surface. The bearings are then clamped together in the usual manner with proper bolts and the crank shaft revolved several times to indicate the high spots on the bearing cap. At the start of the process of scraping in, the bearing may seat at only a few points. Continued scraping will bring the bearing

surface practically across the brass, which is a considerable improvement, while the process may be considered complete when the brass indicates a bearing all over. The high spots are indicated by blue, as where the shaft does not bear on the bearing there is no color. The high spots are removed by means of scraping tools of the form

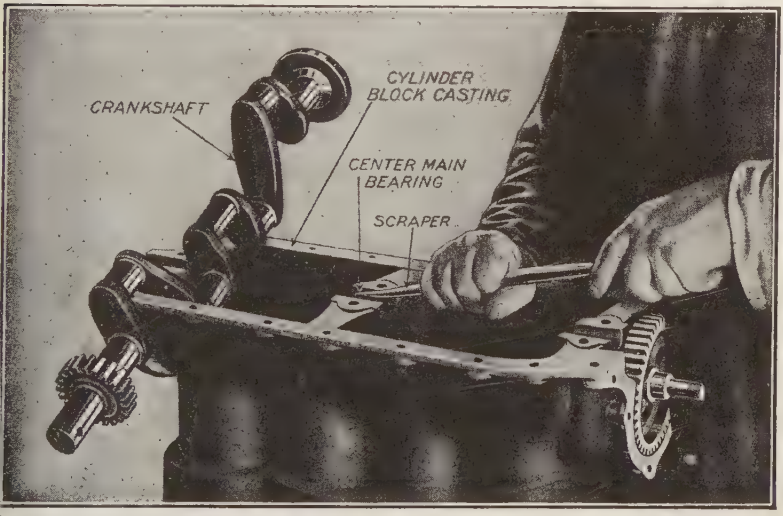


Fig. 81.—Showing Method of Scraping in Main Bearings to Fit Crank Shaft Journals.

shown at Figs. 81 and 85, which may be easily made from wornout files. These are forged to shape and ground hollow and are kept properly sharpened by frequent rubbing on an ordinary oil stone. To scrape properly the edge of the scraper must be very keen. The straight or curved half round type works well on soft bearing metals such as babbitt or white brass, but on yellow brass or bronze it cuts very slowly and as soon as the edge becomes dull

considerable pressure is needed to remove any metal, this calling for frequent sharpening.

When correcting errors on flat or curved surfaces by handscraping, it is desirable, of course, to obtain an evenly

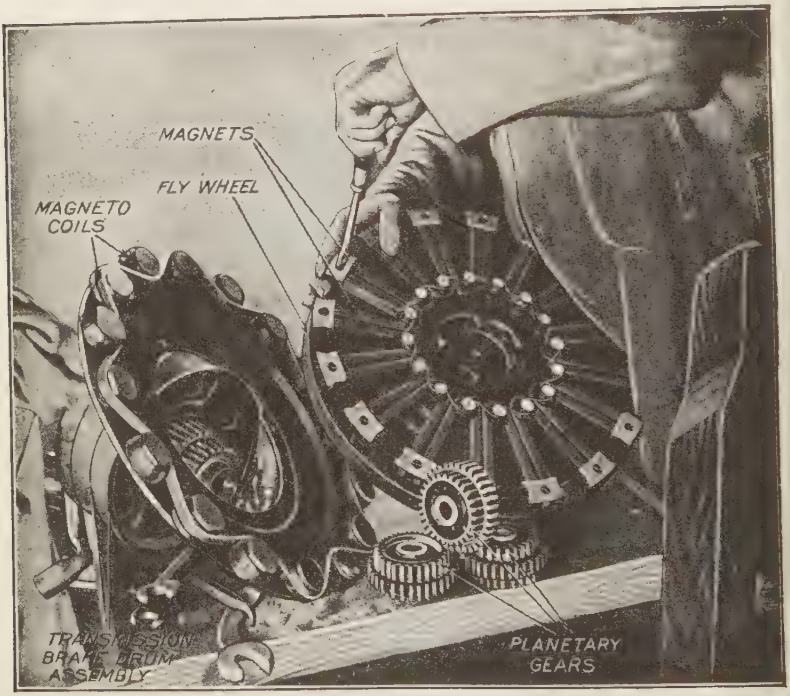


Fig. 82.—Method of Fastening Magnets in Place on Flywheel. Note Planetary Triple Gear Assemblies of Transmission in Foreground.

spotted bearing with as little scraping as possible. When the part to be scraped is first applied to the surface-plate, or to a journal in the case of a bearing, three or four "high" spots may be indicated by the marking material The time required to reduce these high spots and obtain a bearing that is distributed over the entire surface de-

pends largely upon the way the scraping is started. If the first bearing marks indicate a decided rise in the surface, much time can be saved by scraping larger areas than covered by the bearing marks, this is especially true of engine bearings. An experienced workman will not only remove the heavy marks, but also reduce a larger area; then, when the bearing is tested again, the marks will generally be distributed somewhat. If the heavy marks which usually appear at first are simply removed by light scraping, these "point bearings" are gradually enlarged, but a much longer time will be required to distribute them.

The number of times the bearing must be applied to the journal for testing is important. The time required to distribute the bearing marks evenly depends largely upon one's judgment in "reading" these marks. In the early stages of the scraping operation the marks should be used partly as a guide for showing the high areas, and instead of merely scraping the marked spot the surface surrounding it should also be reduced, unless it is evident that the unevenness is local. The idea should be to obtain first a few large but generally distributed marks; then an evenly and finely spotted surface can be produced quite easily.

Remetalling and Fitting Connecting Rods.—Fitting and adjusting rod bearings, especially those at the crank pin end is one of the operations that must be performed several times a season if a car is used to any extent. There are two forms of connecting rods in general use, known respectively as the marine type, and the hinged form. The hinge type is the simplest, but one clamp bolt being used to keep the parts together as the cap is hinged to the rod end on one side, this permitting the lower portion to

swing down and the crank pin to pass out from between the halves when the retaining bolt is removed. In the marine type, which is that used on the Ford Model T, one bolt is employed at each side and the cap must be removed entirely before the bearing can be taken off of the crank pin. The tightness of the brasses around the crank pin can never be determined solely by the adjustment of the bolts, as while it is important that these should be drawn up as tightly as possible the bearing should fit the shaft without undue binding even if the brasses must be scraped to insure a proper fit. As is true of the main bearings the marine form of connecting rod may have a number of liners or shims interposed between the top and cap portions of the rod end, and these may be reduced in number when necessary to bring the brasses closer together.

Before assembling on the shaft, it is necessary to fit the bearings by scraping, the same instructions given for restoring the contour of the main bearings applying just as well in this case. It is apparent that if the crank pins are not round no amount of scraping will insure a true bearing. A point to observe is to make sure that the heads of the cap retaining bolts are imbedded solidly in their proper position and that they are not raised by any burrs or particles of dirt under the head which will flatten out after the engine has been run for a time and allow the bolts to slack off. Similarly, care should be taken that there is no foreign matter under the brasses and the box in which they seat. To guard against this, the bolts should be struck with a hammer several times after they are tightened up and the connecting rod can be hit sharply several times under the cap with a wooden mallet or lead hammer.

Care should be taken in screwing on the retaining nuts to insure that they will remain in place and not slack off. Spring washers should never be used on either connecting rod ends or main bearing bolts because these sometimes snap in two pieces and leave the nut slack. The best method of locking is to use well-fitting split pins and castellated nuts as supplied.

The following advice from the Ford Manual is pertinent:

"Remember, there is a possibility of getting the bearings too tight, and under such conditions the babbitt is apt to cut out quickly, unless precaution is taken to run the motor slowly at the start. It is a good plan after adjusting the bearings to jack up the rear wheels and let the motor run slowly for about two hours (keeping it well supplied with water and oil) before taking it out on the road. Whenever possible these bearings should be fitted by an expert Ford mechanic."

If the babbitt lining is worn sufficiently so it must be replaced or if it has been burned out by running the engine without oil, the connecting rod and cap must be rebabbitted. The Ford makers advise returning the connecting rods to the factory or to the nearest service station. They advise as follows:

"Worn connecting rods may be returned, prepaid, to the nearest agent or branch house for exchange at a price of 75 cents each to cover the cost of rebabbitting. It is not advisable for any owner or repair shop to attempt the rebabbitting of connecting rods or main bearings, for without a special jig in which to form the bearings, satisfactory results will not be obtained. The constant tapping of a loose connecting rod on the crank shaft will eventually produce crystallization of the steel—result, broken

crank shaft and possibly other parts of the engine damaged."

If the parts are wanted in a hurry, it is possible for any competent repair man to rig up and replace the lining metal himself, though this will not be a profitable operation if the parts can be procured from the factory in time.

The repair man who is called upon to replace the bearing metal will find the following instructions regarding remetalling bearings of value. The method described was used by the writer while in charge of a large shop where much work of this kind was done, and while instructions given apply specifically to lining the big ends of connecting rods the same process may be used successfully on any other bearings where the mandrel and collars can be used, the dimensions being changed to suit the requirements of the worker. Obviously the old metal must be thoroughly cleaned out and rod end made ready to receive the new lining before any attempt is made to pour in new metal.

In the case mentioned the journals of the crank shaft were two inches in diameter and the big ends of the connecting rods were worn too much to allow of adjusting. A piece of pipe about 9 inches long was procured and turned down in a lathe until it was a shade under 2″ in diameter, which made a hollow mandrel of it. A piece of steel tubing could have been used to as good advantage had any been available. As the outside of the bearing caps were machined true a couple of set collars were bored out to be a good fit on the mandrel, and while still in the lathe they were recessed out to just fit over the outside of the big ends, as shown in sketch, Fig. 83. One of these collars was placed on the hollow mandrel, A, after which

the mandrel was pushed through the big end, and the other collar was put on the other side, insuring that the mandrel was as near the center as possible for it to be.

The assemblage is then supported on a couple of V-

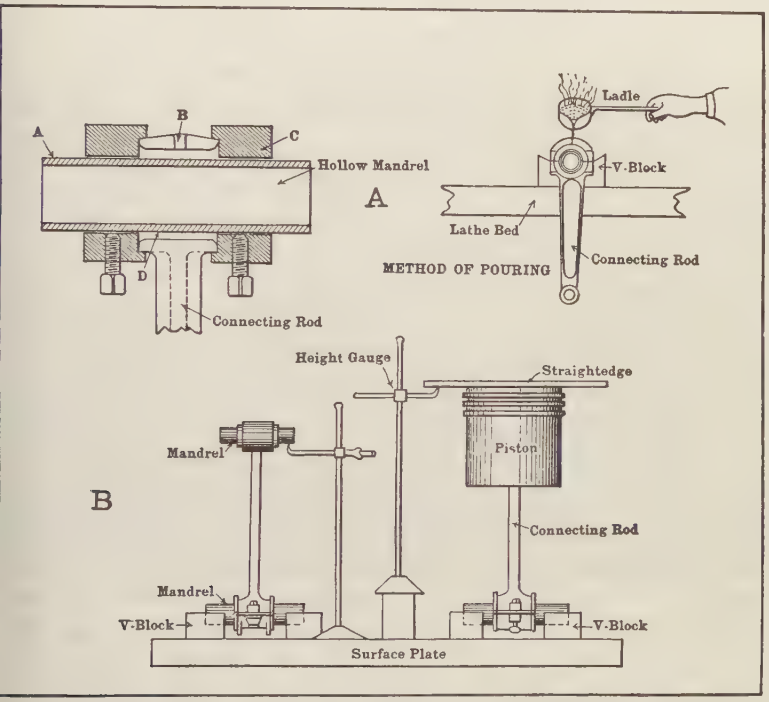


Fig. 83.—Illustrations Showing Method of Rebabbitting Connecting Rod Bearings at A and Method of Testing Connecting Rod Bearing Parallelism at B.

blocks which are supported on a lathe bed, the ends of the mandrel lying within the V's, while the connecting rod hangs between the ways. A piece of solid round iron or steel which will go inside of the hollow mandrel should be made red hot while the anti-friction metal is being

melted and is pushed inside the mandrel to heat it. In a minute or two the metal may be poured in through B to fill annulus D, and as the metal and the big end caps are well heated the molten metal will flow to every point.

The heating of the mandrel can be just as well accomplished by directing the flame from a blow torch or Bunsen burner into the opening. After the metal is poured and has set well the whole may be easily cooled by directing a blast of air against the big end. During the pouring process the cap is separated from the rod end by shims of oiled cardboard. This is afterward replaced by brass shims. As is evident, the thinner the liners and the greater the number used, the more sensitive the character of future adjustment possible. A hollow mandrel is to be preferred to a solid one because of the ease with which it can be heated and cooled. The mandrel should be about .025″ smaller than the crank pins. Vents should be made for the heated gases by grooving the face of each of the collars nearest the big end and on the same side as the hole through which the metal is poured. If provision is not made for "venting" the molten metal will not run uniformly and will become honeycombed. After cooling, the bearing is either bored out in a lathe to the size of the journal or scraped to a fit by hand. The method of pouring the molten metal is clearly shown while the sectional view makes the construction and application of the mandrel clear. The same method may be used to rebabbitt main boxes except that a pair of collars will be needed for each bearing and a long mandrel used to insure proper alignment of the three bearings.

Testing Bearing Parallelism.—It is not possible to give other than general directions regarding the proper degree

of tightening for a connecting rod bearing, but as a guide to correct adjustment it may be said that if the connecting rod cap is tightened sufficiently so the connecting rod will just about fall over from a vertical position due to the piston weight when the bolts are fully tightened up as in Fig. 84, the adjustment will be nearly correct. As pre-

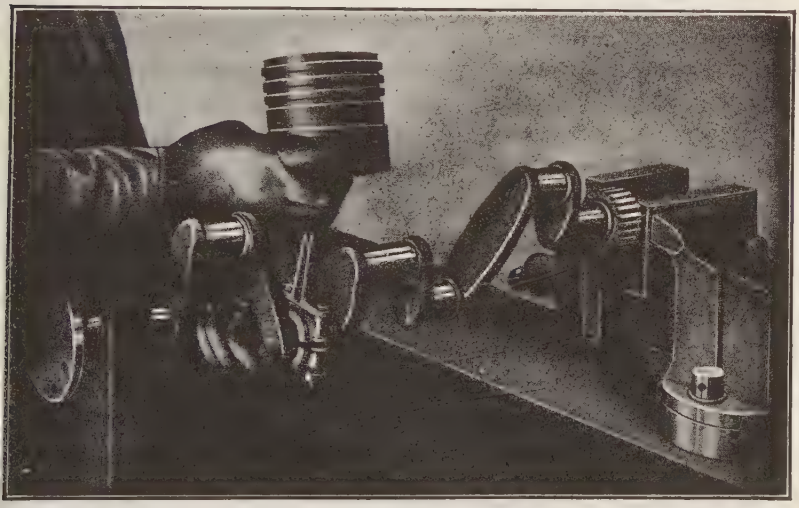


Fig. 84.—Connecting Rod Bearings May be Easily Fitted to the Crank Shaft if This Member is Removed from the Engine and Supported by Bench Vise.

viously stated, babbitt or white metal bearings can be set up more tightly than bronze, as the metal is softer and any high spots will soon be leveled down with the running of the engine. It is important that care be taken to preserve parallelism of the wrist pins and crank shaft while scraping in bearings. This can be determined in several ways. That shown at Fig. 83, B, is used when the parts are not in the engine assembly and when the connecting rod bear-

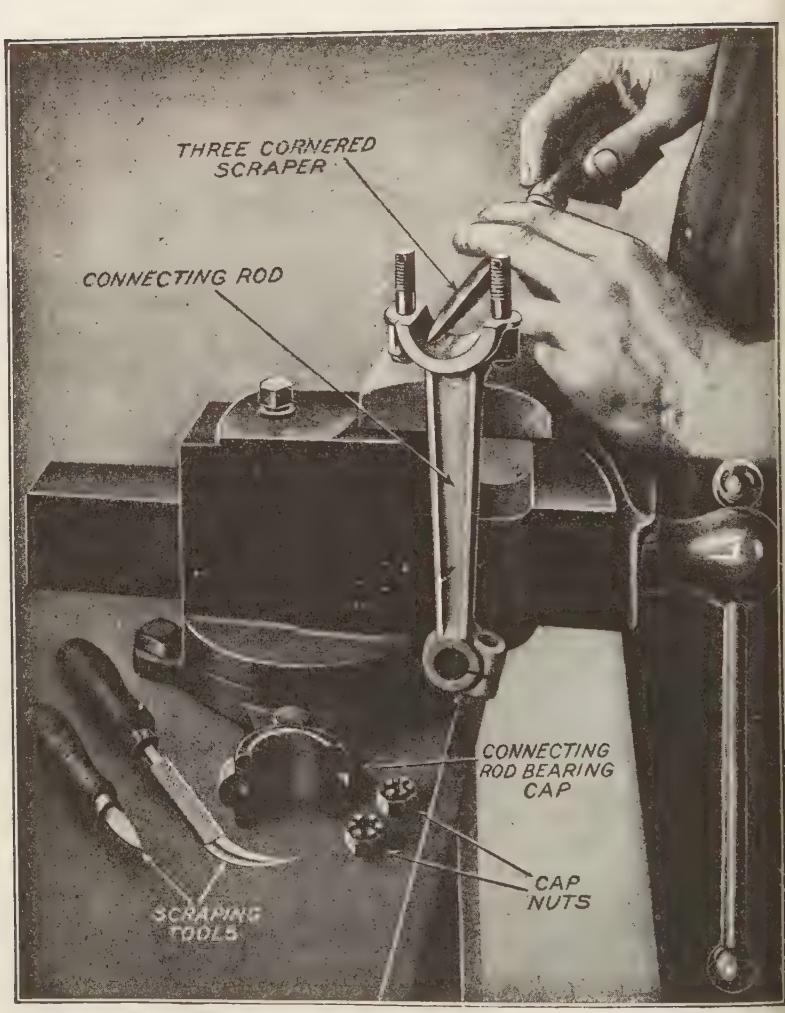


Fig. 85.—Illustrating Method of Scraping In Connecting Rod Bearings and Tools Used in This Process.

ing is being fitted to a mandrel or arbor the same size as the crank pin. The arbor, which is finished very smooth and of uniform diameter, is placed in two V-blocks which in turn are supported by a level surface plate. An adjustable height gauge may be tried, first at one side of the wrist pin which is placed at the upper end of the connecting rod, then at the other and any variation will be easily determined by the degree of tilting of the rod. This test may be made with the wrist pin alone or if the piston is in place a straight edge on the piston top may be employed. A spirit level will readily show any inclination, while the straight edge is used in connection with the height gauge as indicated.

Camshafts and Timing Gears.—Knocking sounds are also evident if the camshaft is loose in its bearings and also if the timing gears are loose on the shaft. The camshaft is usually supported by solid bearings of the removable bushing type having no compensation for depreciation. If these bearings wear the only remedy is replacement with new ones. Another point to watch is the method of retaining the camshaft gear in place. On some engines the gear is fastened to a flange on the camshaft by retaining screw. These are not apt to become loose, but where reliance is placed on a key, as in the Ford, the camshaft gear may often be loose on its supporting member. The only remedy is to enlarge the key slot in both gear and shaft and to fit a larger retaining key.

If the camshaft is sprung or twisted it will alter the valve timing to such an extent that the smoothness of operation of the engine will be materially affected. If this condition is suspected the cam shaft may be swung on lathe centers and turned to see if it runs out and if bent it can be straightened in any of the usual forms of

shaft straightening machines. The shaft may be twisted without being sprung. This can only be determined by supporting one end of the shaft in an index head and the other end on a milling machine center. The cams are then checked to see that they are separated by the proper degree of angularity. This process is one that requires a thorough knowledge of the valve timing of the engine in question and is best done at the factory where the engine was made. The timing gears should also be examined to see if the teeth are worn enough so that considerable back lash or lost motion exists between them. A worn timing gear not only produces noise but it will cause the time of opening and closing of the engine valves to vary materially.

Valve Timing Method.—Among the factors making for efficient operation of the gasoline engine, especially of the multiple cylinder type used for automobile propulsion, there is none of more importance than proper valve timing. In the Ford four cylinder four-cycle motor there are eight of these members, two to each cylinder, the function of the inlet valves being to permit the cylinders to fill with gas while the exhaust valves open to clear the cylinders of the products of combustion. The inlet valve usually opens when the piston is at approximately the top of its stroke in the cylinder or during that portion of the engine cycle where the piston is starting to go down to draw in a charge of gas. This valve is opened at a period equal to the downstroke of the piston and sometimes more, but is closed during the succeeding compression, explosion and scavenging strokes. The operation of the exhaust valve is very much the same as the inlet except that it is opened for a longer period, starting to open before the piston has completed the downward stroke produced by the explosion and

is sometimes opened slightly after the end of the return or scavenging stroke.

When the space between the valve stem and the valve lifter is more than it should be there are two methods of compensating for this depreciation. On many small motors no adjustment is provided between the valve stem and the valve stem plunger. The makers of the Ford car formerly advised drawing the valve stem out until the proper space existed between the push rod and the stem. It is important when drawing out the stem or lengthening it not to bend the valve stem as this will result in the valves sticking, or in any event the bore of the valve stem guide in the cylinder will be worn unevenly. The clearance between the pushrod and the valve stem should never be greater than $\frac{1}{32}''$ nor less than $\frac{1}{64}''$. If too much clearance is present the valve will open late and close early. If the clearance is less than the minimum there is danger of the valve remaining partially open all of the time because the valve stem lengthens due to expansion produced by the heat of the explosion. When it is necessary to draw down a valve stem this should be done by peening it for about $\frac{3}{4}''$ above the pinhole or key slot.

It is not a difficult matter to set the clearance exactly as it should be on those types of engines provided with an adjustment screw which may be raised or lowered in the valve plunger or, in forms having fiber inserts in the top of the valve plunger. These inserts are utilized to silence the valve action and may be easily removed and replaced with new ones when worn. A simple and cheap accessory that can be obtained on the open market can be used to adjust the clearance on Ford and similar type motors. This consists of a number of stamped steel cups that can be pushed on the lower portion of the valve stem and a

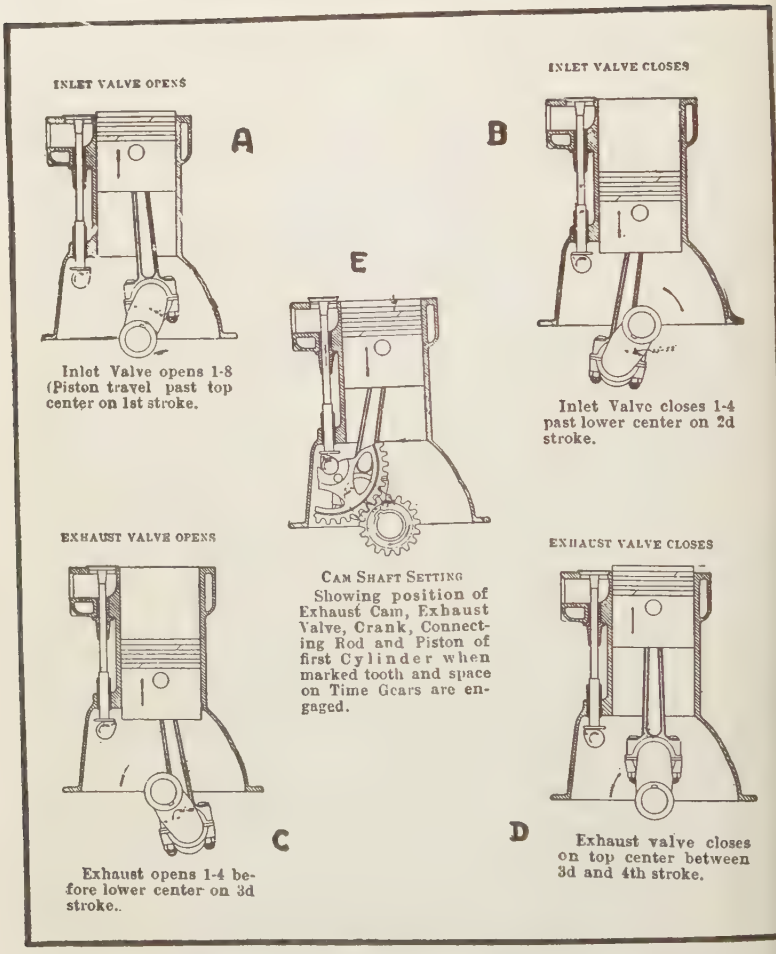

INLET VALVE OPENS
A
Inlet Valve opens 1-8 (Piston travel past top center on 1st stroke.
INLET VALVE CLOSES
B
Inlet Valve closes 1-4 past lower center on 2d stroke.
E
CAM SHAFT SETTING
Showing position of Exhaust Cam, Exhaust Valve, Crank, Connecting Rod and Piston of first Cylinder when marked tooth and space on Time Gears are engaged.
EXHAUST VALVE OPENS
C
Exhaust opens 1-4 before lower center on 3d stroke..
EXHAUST VALVE CLOSES
D
Exhaust valve closes on top center between 3d and 4th stroke.

Fig. 86.—Diagram Showing Method of Timing Ford Valves.

number of thin steel washers to be interposed inside of the cup and between the bottom of that member and the end of the valve stem to regulate the clearance as desired.

Valve Timing in Ford Engines.—After the valves have been ground in and seated properly it is important that the timing of the valves be verified. As the valves have been properly timed when the engine is assembled at the factory the only reason for checking the timing would be during the overhauling when the camshaft or timing gears have been removed from the engine base. In fitting the large timing gear to the camshaft it is important to see that the first cam points in a direction opposite from the zero mark as shown at Fig. 86, E. The large and small time gears must also mesh, so that the tooth marked 0 on the small timing gear will coincide with a similar mark between the two teeth on the large gear. With the timing gears set as indicated the exhaust valve in No. 1 cylinder is opened and the intake valve closed.

The opening and closing point of the valves is as follows: The intake valve opens with the piston $\frac{1}{16}$ of an inch down from top center as shown at Fig. 86, A. The inlet valve closes $\frac{9}{16}$ inch after the piston has reached bottom center as shown at Fig. 86, B, the distance from the top of the piston to the top of the cylinder casting measuring $3\frac{1}{8}$th inches. The exhaust valve opens when the piston reaches a point on its travel from $\frac{5}{16}$th inch to $\frac{1}{4}$ inch before lower center on third stroke, as shown at Fig. 86, C. The distance from the top of the piston head to the top of the cylinder casting at the time the exhaust valve starts to open is $3\frac{3}{8}$ inches. The exhaust valve should close on top center between the third and fourth strokes as shown at Fig. 86, B. The piston top at this time is $\frac{5}{16}$ inch above the cylinder casting. The clearance between the push rod and valve stem should be carefully gauged as previously mentioned. Obviously this gap should be measured when the push rod is at the extreme lower point of its travel

or riding on the rounded portion and not the point of the cam.

When the push rods or valve stems become worn so as to leave too much play between them, it is best to replace with new push rods. The operation of drawing down the valve stems requires considerable experience and the price of the new part does not warrant the time and expense necessary to do the work as it should be done. Mention has been made of simple clearance adjusters made especially for Ford valves but these are not marketed by the Ford people and can only be obtained from supply houses. If the valves fail to seat themselves properly there is a possibility that the valve springs may be weak or broken. It is stated that a weak inlet valve spring will not affect the running of the engine as much as a sluggish acting exhaust valve spring. Weakness in a valve spring can be easily detected by removing the cover plate and inserting a screw driver between the coils of the spring while the engine is running. Each of the exhaust valve springs is tried in turn, and if the extra tension thus produced results in the engine picking up speed the spring is too weak and should be replaced with a new one.

Repairing Ford Magneto.—While the engine is dismantled it is a good time to make any repairs that may be necessary to the magneto, these being rarely needed on account of the simplicity of the device. The Ford magneto consists of permanent magnets, and there is not much liability of their losing their strength unless acted upon by some outside force, though cases have been known where much of the magnetism has been lost due to overheating the engine. If a dry or storage battery has been attached to the magneto terminal by mistake the magnet strength

nay be weakened. If on testing with a special instrument nade for the purpose, the magneto does not show the proper current, instead of attempting to recharge the magnets the best and cheapest way is to install a complete set of new ones. These may be obtained from the factory or nearest agent and will be placed on a board in exactly the same manner as they should be installed on the flywheel. The magnets may be easily removed from the flywheel as outlined at Fig. 82. Great care should be taken when assembling the magnets and lining up the parts so that the pole pieces of the magnets will be separated from the surface of the coil spools carried by the stationary plate by no more than $\frac{1}{32}$nd of an inch. To take the old magnets from the flywheel simply remove the cap screw and bronze screw which holds each in place.

The magneto is often blamed when the trouble is a weak current that results by waste or other foreign matter accumulating under the current collecting contact plunger which is held in place by the binding post carrier on top of the transmission case cover. Remove the three screws which serve to retain this collecting terminal in place, this allows the binding post to spring up and plunger to be withdrawn. The contact pad on top of the fixed coil assembly should be thoroughly cleaned and the end of the plunger brightened with emery cloth before it is replaced. The magneto cannot be reached for replacing magnets without taking the power plant out of the car. After the crank case and transmission covers are off, the flywheel may be taken off of the flange on the end of the crank shaft by removing four cap screws that hold the flywheel to that member. Whenever repairs are necessary to the magneto such as replacing magnets or making sure that all magnet retaining screws and bolts are tight, the best way is to

have the parts on a bench where they may be easily reached, as shown at Fig. 82.

Packings and Gaskets for Ford Motor.—If the power plant has been taken apart it may be found desirable to replace the various gaskets and packing members with new ones when reassembling the parts. This applies especially to the felt packings, which are apt to be torn when the pieces resting on them are removed quickly. The copper

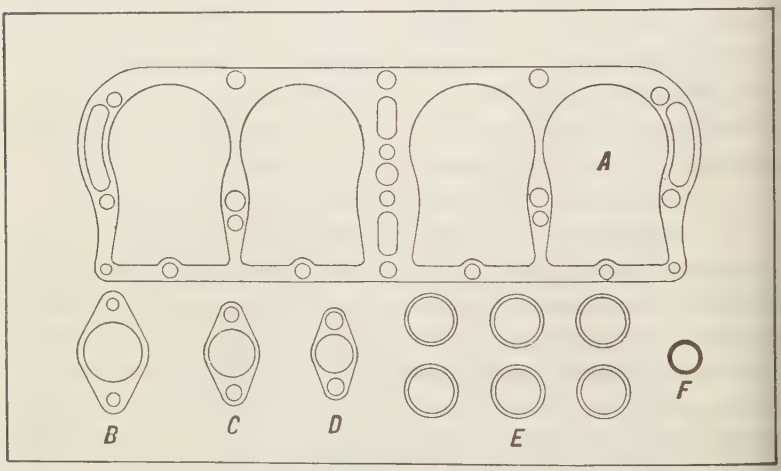


Fig. 87.—Copper Asbestos Gaskets Used on Ford Motor.

asbestos gaskets which are used as packings on the combustion chamber end of the engine do not depreciate as readily as those made of felt, though when these flatten out it may be well to replace them with new, because they are so cheap that it would be questionable economy to use them if there was any doubt about their condition.

A set of the copper-asbestos packings for the cylinder heads of the Ford engine is shown at Fig. 87. That at A, is the member placed between the cylinder head and cylin-

der block, those at B and C are used between the water connections, those at E are placed under the inlet and exhaust manifolds; that at D is placed between the carburetor and flange on the lower portion of the inlet manifold, while the small packing at F is used at the lower portion of the crank case or flywheel compartment as a seating for the oil drain plug.

The felt packings are clearly shown at Fig. 88. The strips at A, are placed between the pressed steel crank case member and the cylinder block. The piece marked M, is employed between the top of the transmission case and the pressed steel lower portion. The large packing, C, is placed between the bottom plate of the crank case and the pressed steel lower crank case member. Packing D is utilized under the transmission case cover plate on late model Ford cars, while that shown at E is used on some of the earlier models having a square cover plate.

The small corner pieces, B, are used on the valve chamber cover plates. The gasket, F, goes between the members of the universal joint ball housing. Piece H fits under the magneto collecting brush terminal fitting. Washers I, J, K and L, are oil retention members for the front and rear axles. The control bracket felts are placed in recesses in the supporting bearing of the cross shaft to which the hand brake control lever is fastened and serve to retain oil and insure adequate lubricity of the cross shaft.

The crank case arm felts are intended to be placed between the arms and the frame side member. The strips shown which are not lettered are used to complete the packing between the timing gear case portions and between the upper transmission case and round portion

against which it fits on the engine base. When replacing either the copper asbestos or felt packings it is well to coat these with heavy shellac before the parts are assembled. The shellac fills any irregularities that may exist in the surfaces and prevents oil leakage.

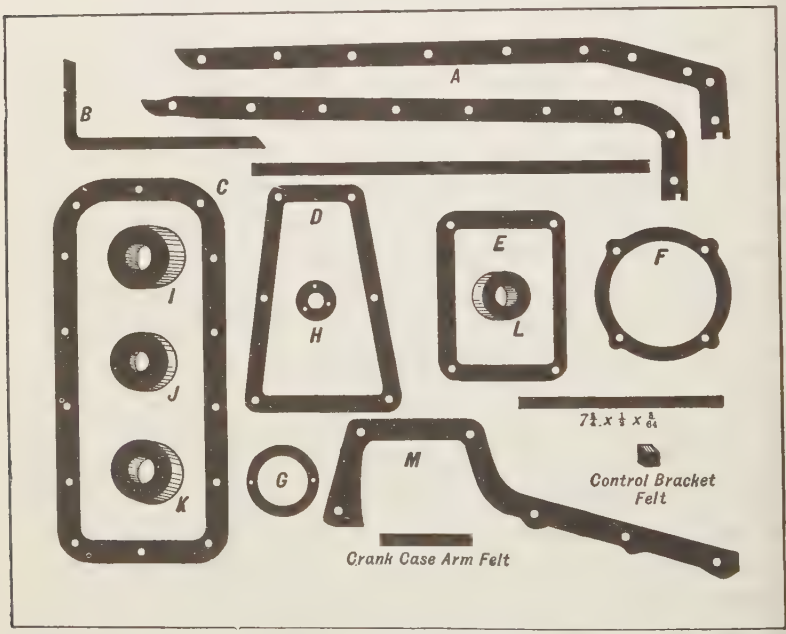


Fig. 88.—Group Showing Felt Packings for Ford Power Plant and Also for Retaining Oil in Running Gear Parts.

Precautions in Reassembling Parts.—When all of the essential components of a power plant have been carefully looked over and cleaned and all defects eliminated, either by adjustment or replacement of worn portions, the motor should be reassembled, taking care to have the parts occupy just the same relative positions they did be-

fore the motor was dismantled. As each part is added to the assemblage, care should be taken to insure adequate lubrication of all new points of bearing by squirting liberal quantities of cylinder oil upon them with a hand oil can or syringe provided for the purpose. In adjusting the crank shaft bearings tighten them one at a time and revolve the shaft each time one of the bearing caps is set up to insure that the newly adjusted bearing does not have undue friction. All retaining keys and pins must be positively placed and it is good practice to cover such a part with lubricant before replacing it because it will not only drive easier but the part may be removed more easily if necessary at some future time if no rust collects around it.

When a piece is held by more than one bolt or screw, especially if it is a casting of brittle material such as cast iron, the fastening bolts should be tightened uniformly. If one bolt is tightened more than the rest it is liable to spring the casting enough to break it. This applies especially to the Ford water connection castings. Spring washers, check nuts, split pins or other locking means should always be provided, especially on parts which are in motion or subjected to a load. When reassembling the inlet and exhaust manifolds it is well to use only perfect packings or gaskets and to avoid the use of those that seem to have hardened up or flattened out too much in service. If it is necessary to use new gaskets it is imperative to employ these at all joints on manifold because if old and new gaskets are used together the new ones are apt to keep the manifold from bedding properly upon the used ones.

It is well to coat the threads of all bolts and screws subjected to heat, such as cylinder head bolts and exhaust

pipe retaining nut, with a mixture of graphite and oil. Those that enter the water jacket should be covered with white or read lead or pipe thread compound. Gaskets will hold better if coated with shellac before manifold or other parts are placed over them. The shellac fills any irregularities in the joints and assists materially in preventing leakage after the joint is made up and the coating has a chance to set. In replacing cylinder head packings on cars like the Ford it is well to run the engine for a short while, several minutes at the most, without any water in the jacket in order to heat the head up thoroughly. It will usually be found possible to tighten down a little more on all of the cylinder head retaining bolts after this is done because if the gasket has been coated with shellac the surplus material will have burnt off and the entire packing bedded down. Care should be taken when using shellac, white or red lead, etc., not to supply so much that the surplus will run into the cylinder, water jacket or gas passages.

Taking Down Transmission.—After the car has been in use for a considerable period, especially in sections of the country where frequent use of the slow speed gearing is necessary, the transmission will become very noisy in action and will rattle and grind when either the slow or reverse brake bands are operated. Owing to the fact that there are no gears in operation on the high speed but little trouble will be experienced with the clutch disc assembly unless the disc surfaces have become roughened or have worn enough so that no further adjustment is possible with a clutch adjusting screw. While the power plant is out of the frame it will be found desirable to take the transmission gearing apart and examine the various fastenings and gears. The gears are not apt to wear

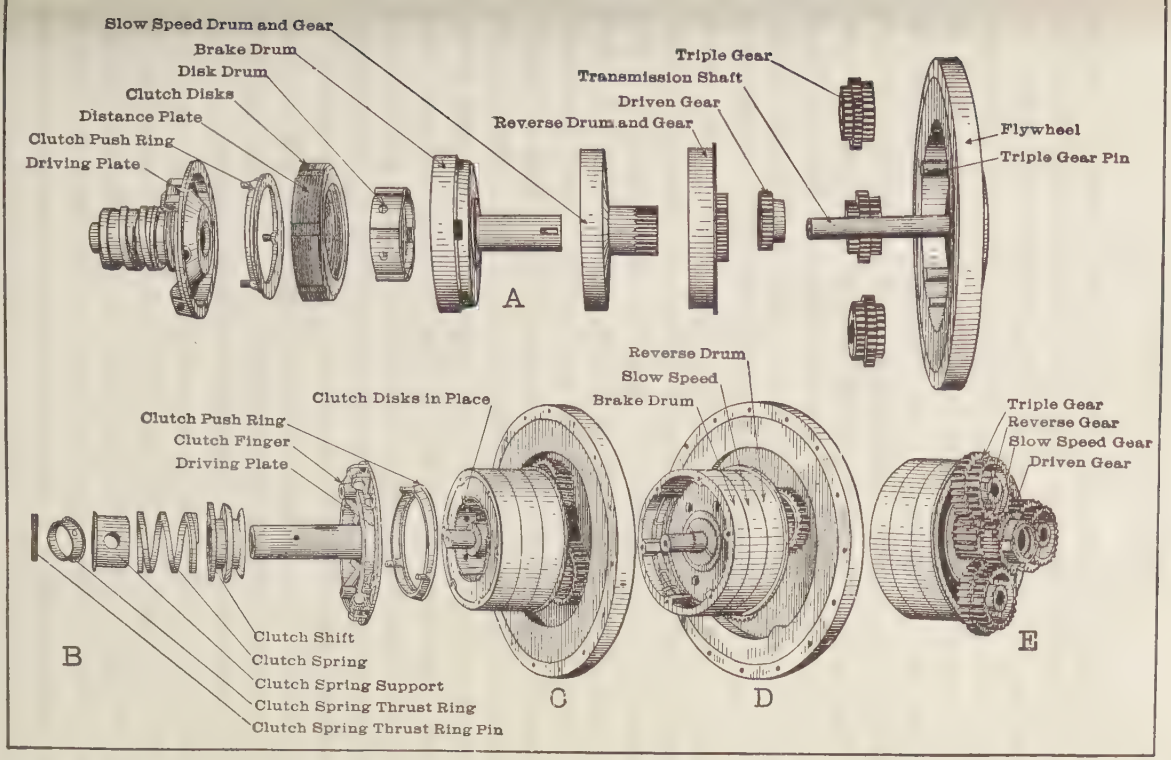


Fig. 89.—Plate Showing Parts Comprising the Ford Transmission When Disassembled at A, and When Joined Together to Form Various Groups to Facilitate Assembly at C, D and E.

very much and practically the only trouble will be depreciation of the bushings that form bearings for the triple gear assembly and the various brake drum members.

In taking the transmission gear apart, the first thing is to drive out the clutch spring thrust ring pin which is shown at Fig. 89, B. This releases the clutch spring thrust ring and the clutch spring supports and makes it possible to remove the clutch spring, clutch shift collar and driving plate. The driving plate can only be taken off after the screws by which it is bolted to the brake drum and clutch carrier are taken out. This exposes the clutch disc assembly as shown at Fig. 89, C. The clutch discs are carried by a member known as "the disc drum" shown in group of parts A, Fig. 89. A set screw passes through this member to key it securely to the crank shaft extension. When this set screw has been properly loosened the clutch disc drum may be removed which leaves the assembly as shown at Fig. 89, D. This assembly, consisting of the reverse drum, slow speed and brake drums and the triple gears, is held on the flywheel. This assembly may be easily withdrawn from the flywheel and the crank shaft extension which is known as the "transmission" shaft which leaves the group as shown at Fig. 89, E. In order to take this down, the driven gear must be removed from the brake drum shaft extension, which will permit the three drums to be pulled apart.

The point to examine carefully after the transmission has been disassembled is to note if the bushings in the triple gear assemblies or if the pins attached to the flywheel used for supporting them are worn. If there is considerable play between the bushings and the pins the bushings should be forced out of the triple gear assemblies and new ones inserted in their place. The triple

gear pins should also be replaced with new ones. The bushings in the reverse drum and gear and in the interior of the slow speed drum and gear should be carefully measured to make sure that the slow speed drum is a good fit on the extending shaft of the brake drum and that the reverse drum is a proper fit on the extension of the slow speed drum. If these bushings are worn so that considerable looseness obtains, the old ones should be driven out and new ones forced in under an arbor press.

Before reassembling the brake drum assembly, care must be taken to fit the bushings so they will turn freely on the members by which they are supported. The relation of the parts to each other in the complete assembly can be readily understood by referring to Fig. 27, which is a sectional view of the transmission gearing. The surfaces of the brake, slow speed and reverse drums should not be cut or scored as might result if the brake lining has been improperly applied and iron rivets used instead of those supplied by the Ford Company. It is not only important to use the proper rivets but they should be properly countersunk.

The transmission clutch discs should be removed from the assembly, thoroughly cleaned and inspected to see if these are smooth or if the surfaces are badly scored. If the contacting faces are ridged, which would result if the operator continually slipped the clutch, the discs should be smoothed off if the ridges are not deep and new ones used if the surfaces are badly scored. While taking the transmission gear apart is not a difficult operation, some skill is needed to insure correct reassembling.

The first operation is to assemble the driven gear, reverse drum and gear, slow speed drum and gear and

brake drum, all of which are shown at Fig. 89, A, to form the group shown at Fig. 89, E. Place the brake drums on a bench or table with the hub extending vertically, then place the slow speed drum over this hub with the gears uppermost. The reverse drum is then assembled over the hub of the slow speed drum with its gear member uppermost. Next, place two Woodruff keys utilized to driving the pinion marked "Driven Gear" shown at A, Fig. 89, in the key ways cut into the brake drum hub just above the slow speed gear. Put the driven gear in place with the teeth downward so they will come next to the slow speed gear. Take the three triple gears and mesh them with the driven gear so that the punch marks on the teeth correspond, the reverse gear, or smallest one of the three comprising the assembly, being downward. When the triple gears have been properly meshed they should be tied in place by passing a cord or wire around the outside of the three gear assemblies which is cut and removed when the group is in place. This group then has the appearance shown at Fig. 89, E.

The next step is to assemble group E on the flywheel. The flywheel is placed on the bench with its face downward so that the transmission shaft projects vertically. Group E is inverted so that the triple gear assembly will face the flywheel, then the group is pushed on the transmission shaft allowing it to settle in such a position that the triple gear supporting pins on the flywheel will pass through the bushings in the triple gear assembly. This will bring the brake drum on top as shown at Fig. 89, D. The next thing to do is to fit the clutch drum key in the transmission shaft and press the clutch disc carrier drum in place on the shaft, locking it into position with a setscrew provided for that purpose. The distance plate,

which is a heavier disc than the clutch plates, is put on the clutch drum first, then a small disc which is followed by a large one, then placing another small disc and alternating large and small ones until the entire set of discs is in position, a large one or member having keyways in its outer periphery, being on top. Care should be taken never to have a small disc or one with keys cut in its inner periphery on top because it is liable to fall over the clutch drum when changing the speed from high to low, and as a result one would be unable to re-engage the high speed clutch.

The appearance with the clutch disc drum and the clutch discs in place is shown at Fig. 89, C. The next step is to put the clutch disc ring over the clutch drum, then put the clutch push ring over the clutch drum and on top of the disc ring with the three pins projecting upward as shown in group of parts B, Fig. 89. The remaining parts to be assembled are placed in the order to be followed in replacing them. Bolt the driving plate in position on the brake drum so the adjusting screws of the clutch fingers will bear against the clutch push ring pins. Before proceeding further the Ford Company advises the worker to test the transmission by moving the plates or drums with the hands. If the transmission is properly assembled the flywheel will revolve freely while holding any of the drums stationary or vice versa.

The clutch parts may be assembled on the driving plate hub as follows: Slip the clutch shift on the hub so the small end rests on the ends of the clutch finger, next put on the clutch spring with the clutch support inside so the flange of that member will rest on the upper coil of the spring. Next place clutch spring thrust ring with notched end down and press into place, inserting the pin

Fig. 90.—Showing How Transmission Cover is Removed to Permit Reaching Transmission Brake Bands.

in the driving plate hub through the holes in the side of the spring support. The easiest method of compressing the spring sufficiently to insert this pin is to loosen the clutch finger tension by backing out the adjusting screw. When tightening up the clutch again the spring should be compressed to a length of 2 or 2 1/16 inches to insure against the clutch discs slipping. The precaution should be taken to see that the screws in the driving plate fingers are adjusted uniformly in order to obtain even compression of the clutch spring.

Relining Brake Bands.—The parts of the transmission gear that will wear soonest and which will need inspection and repair long before the bushings of the gearing have worn are the friction linings in the three transmission brake bands. The only way a new lining can be put on is to remove the brake band from the transmission assembly, which can be done without taking the power plant out of the frame. The first step is to take off the door on top of the transmission cover and to turn the reverse adjustment nut and the brake adjustment nut to the extreme end of the thread on the pedal shaft. This permits the brake bands to expand away from the drum. It is also important to slack off the slow speed adjusting screw. Next remove the bolts holding the transmission cover to the crank case and lift off the cover assembly as shown at Fig. 90.

Slip the band nearest the flywheel over the first of the triple gears, then turn the band around so that the opening is downward. The band can now be removed by lifting upward, as shown at Fig. 91. The operation is more easily accomplished if the three sets of gears are so placed that one set is just a little to the right of center at the top. Each band is removed in the same way. It

is necessary to push each band forward onto the triple gear assemblies as it is only at this point that there is room enough in the crank case to allow the upstanding slotted ears on the transmission bands to be turned down. The bands are replaced by reversing the operation. After being placed in the upright position on drum, a cord is passed around the ears of the three bands so that when putting on the transmission cover no trouble will be experienced in having the pedal shafts rest in the notches made to receive them in the band ears. The clutch release ring must be placed in the rear groove of the clutch shift ring. When the cover is in place remove the cord that held the bands together while the cover was being installed.

The operation of relining a brake band is a relatively simple one, consisting only of pulling off the old brake lining and driving out the retaining rivets from the holes in the band. A new lining is placed inside the band and a piece of steel bar stock is placed in the vise as shown in Fig. 92, to form a backing against which the special rivets are driven by means of a steel drift or rivet set to clinch the lining securely in place. The linings furnished by the Ford makers are the only ones that should be used because serious ignition trouble may be occasioned by particles of wire or impregnating compounds dropping off of linings not made for this purpose getting around the magneto current collecting plunger.

Rear Axle Troubles and Remedies.—If continual grinding noises are heard in the rear axle when the car is being operated on the high speed drive, this is a sign that the gears or the bearings in the rear axle are worn and calls for a thorough overhauling of that member. Wear in bearings can be tested by jacking up the rear

end and lifting upon the wheels in the same way as advised for testing the emergency or rear hub brakes. If it is possible to move the wheel up and down it indicates that either the roller bearings or the axle is worn. Steps

Fig. 91.—Removing Transmission Brake Band for Replacing Friction Lining.

should be taken to correct this, because wear at this point imposes great strains on the roller bearings at either side of the differential.

After a car has been in use for a time and especially if the differential housing has not been kept properly lubricated, the babbitt thrust collars at each side of the differential and the bronze bushings in the differential case may wear sufficiently so that the bevel driving gears will not mesh properly. The best way of making axle repairs is to take this member apart after it has been removed from the chassis and carefully examine all worn parts. The first step in removing the rear axle is to jack up the car and remove the rear wheels as previously described for inspecting the hub brakes. Take out the four bolts connecting the universal joint ball retaining cap to the transmission case and cover. Disconnect the hub brake rods from the cross shaft to which the hand lever is fastened. Raise the frame so that the weight will be released which will permit of removing the spring shackles or the spring perches from the rear axle housing flanges if this method is preferred.

It is not necessary to remove the wheels while the axle is under the car as the spring may be disconnected from the spring perches by taking off the spring shackles. Some repairmen prefer to leave the wheels on as it enables them to roll the axle out from under the car. The first step in taking down the axle is to remove the retaining nuts at the end of the radius rods. Then to remove the drive shaft tube by taking off the nuts on the six retaining studs holding the drive shaft assembly to the rear axle housing. Next remove the bolts which hold the two halves of the differential housing together. The wheels must be removed from the axle shaft to permit

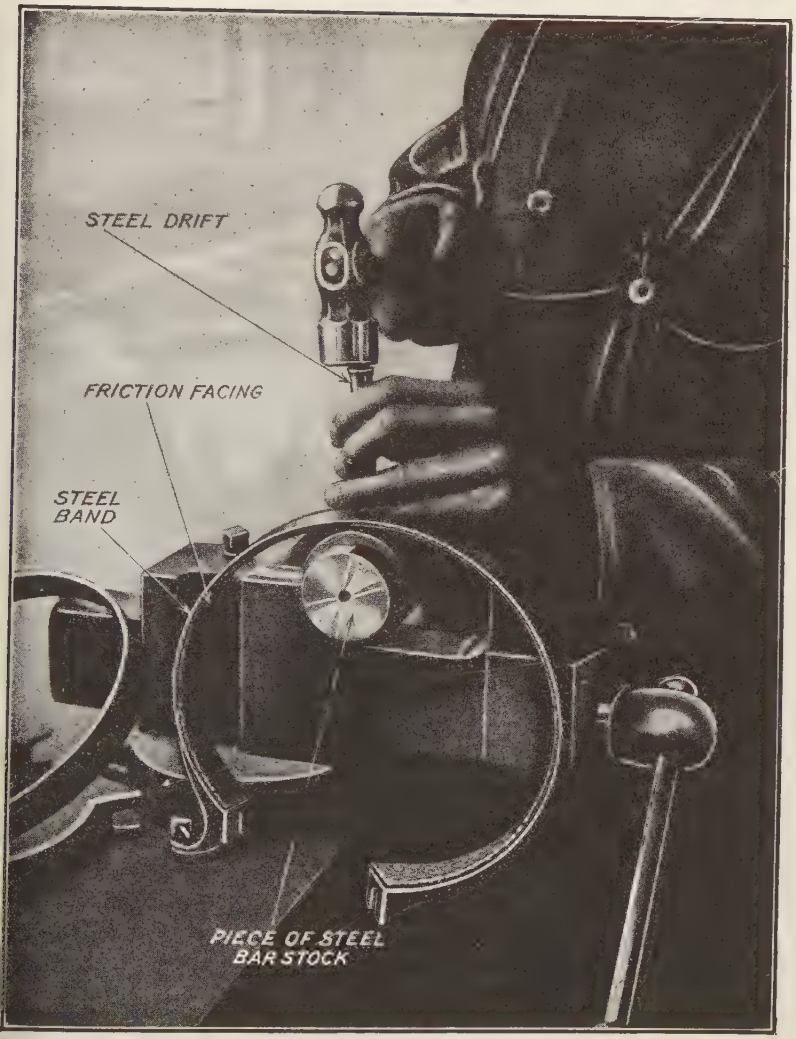


Fig. 92.—How Friction Lining is Riveted to Brake Bands.

one to spread the housings apart as shown at Fig. 93, and obtain access to the differential gear. The two halves of the axle housing may be removed entirely, if desired, thus leaving the differential gear with the two wheel drive shafts extending from it, one at either side.

The gear teeth should be carefully examined, especially those on the bevel drive pinion which are apt to wear more quickly than those of the bevel ring gear on account of their being a lesser number to transmit the power. If the pinion teeth surfaces have flaked or if portions of the teeth are broken, a new pinion should be installed in place of the defective one. Before installing a new pinion care should be taken to see that there is no lost motion in either the ball or roller bearings, back of the pinion. Any play in these members must be removed by fitting new bearings because these are the most important bearings in the entire axle mechanism. Any play in these bearings may result in loss of alignment between the driving and driven gears.

The pinion may be easily removed from the end of the drive shaft by taking out the locking pin passing through the castelated nut and removing the nut, then drawing the pinion off the drive shaft with a suitable gear puller. The babbitt thrust washers and the steel plates on each side of them should be examined to see that these are not worn and the axles should be grasped and moved up and down to see if there is any play between them and the differential casing. If any looseness is present at this point it is because the bronze bushings in the differential casing that bear on the hubs of the compensating gears have worn. The differential casing is taken apart by unloosening the through bolts which frees the two halves of the casing. This exposes the compensating gears, and

if these have been damaged as might result if a piece of broken pinion tooth was to get into the differential mechanism, it is necessary to remove the compensating gears from the axle shaft.

On examination it will be seen that the gears are keyed on and are held in position by a ring which is in two

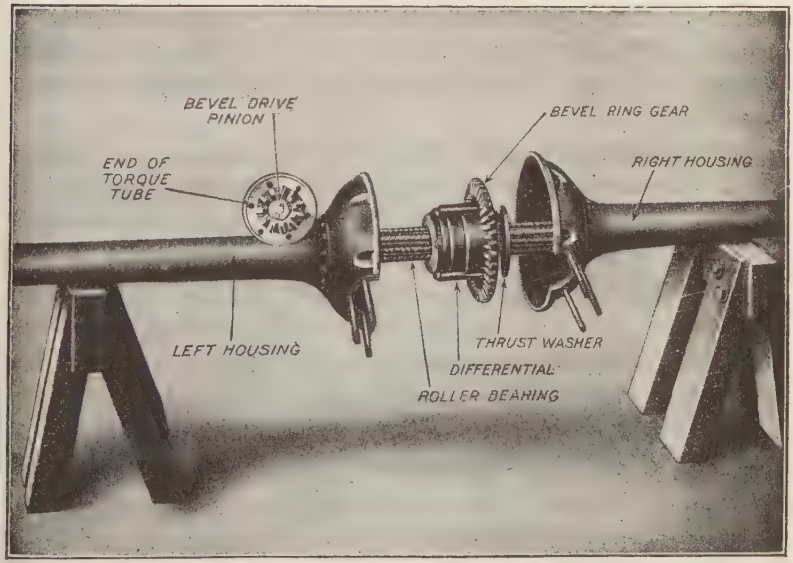


Fig. 93.—Rear Axle Partially Disassembled to Show Differential and Supporting Bearings.

halves and which fits in a groove in a shaft. To remove the gears they must be forced down on the shaft away from the end to which they are secured in order to expose the rings which are removed from the grooves to permit the gears to be forced off the end of the shaft. If the roller bearings have worn and the shaft is not cut or worn in at the bearing point a new roll and cage assembly

may be installed. Sometimes the steel lining or shell placed in the axle housing will wear. This may be easily removed and a new one inserted. If the axle shaft is reduced in diameter at the bearing point the only means of restoration possible is to replace the entire axle shaft. Leakage of oil or grease out of the axle is usually because the two halves are not securely bolted together if the leak is around the differential housing or because the felt retaining washers at the wheel end of the axles have depreciated. This may be suspected if the brakes have become fouled with oil.

Miscellaneous Chassis Parts.—There are a number of minor points about the chassis which demand inspection and in some cases adjustment when a car is overhauled. The most important of these is the front axle and steering connections. The front wheels should be inspected to make sure that they are in proper adjustment and that they run smoothly without appreciable side play. The bearings should be thoroughly cleaned and looked over to see that there are no broken balls and that the cones and ball races have not become pitted or roughened on the ball track. If there is much play in the steering rods or in the bearings supporting the steering spindle bolt the only remedy is to drive out the worn bushings and replace with new ones, which will be an inexpensive operation.

If the front wheel is in proper adjustment it should spin easily and come to rest with the tire valve at the bottom. If the ball bearings in the front wheels wear out quickly it is usually due to water getting into the bearings, the use of lubricant containing acid or improper bearing adjustment. One can be sure that no water will get into the bearings if the felt washer on the inside of

the wheel hub is in proper condition and if the front hub interior is filled with the proper grade of mineral grease. The rear wheels should be inspected after the car has been driven for a time to make sure that these fit the taper ends of the axle shafts tightly.

If there is considerable rattling and knocking at the front end of the car and the trouble is not due to loose engine bearings it is often caused by the ball joint at the end of the front axle radius member being loose. This may be tightened up by removing the cap and grinding off some of the cap face in order to have it set more tightly against the ball and to force that member into more intimate contact with the hemispherical seat on the front side of the flywheel compartment. Special spring adjusted caps are now furnished by the Ford Company. Rattling is also caused by loose steering connections and by loose mud guards.

Squeaking noises result when the springs become rusty and no lubricant is present between the leaves. While the car is being overhauled it is a good plan to remove the springs from the chassis and to take these apart, cleaning off the surfaces with emery cloth and smearing them with a mixture of graphite and oil before reassembling. It is a very simple matter to remove the springs from the Ford frame as these are held by readily detachable spring clips, shown at Fig. 93. Both front and rear springs may be removed by taking off two spring clips and two spring shackles. It is important to jack up the frame so the weight will be taken off the springs before any attempt is made to remove these from the chassis.

After a car has been in service two or three years, excessive play in the steering gear may result from depreciation of the teeth of the small planetary pinions and

internal gear mounted under the steering wheel spider. These must be replaced with new ones when worn. The steering wheel is removed from the steering column by unloosening the nut on top of the wheel spider and pulling off the spider hub from the shaft to which it is fastened. The interior of the steering gear may be easily inspected after the steering wheel is removed by loosening a set

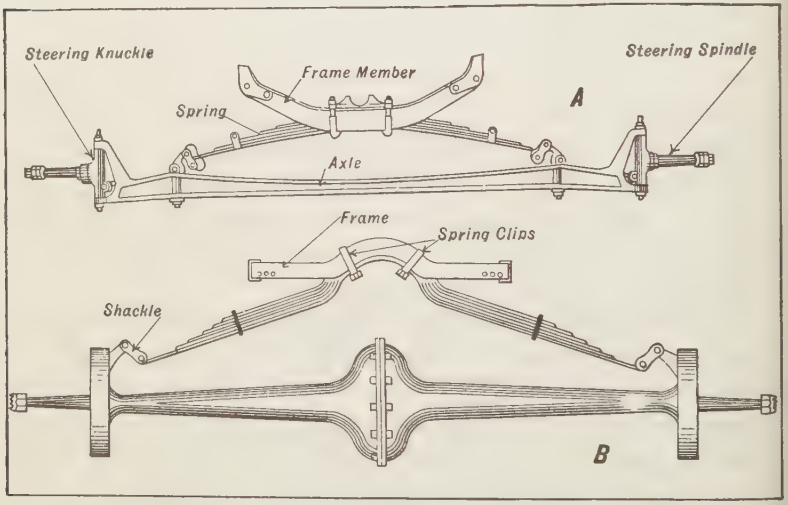


Fig. 94.—Outlining Method of Ford Front and Rear Spring Retention.

screw and unscrewing the brass cap that is a cover for the reduction gear case. If a wheel puller is not available for taking the steering wheel off of the steering post it may be driven off of the shaft with a block of wood and a hammer.

In addition to the main points mentioned there are a number of minor bearing points such as the bushings in the spring eyes, the shackle bolts and the various rod

ends and pins at the joints of the control rods which will wear and produce their quota of noise. The bolts employed for holding the body to the chassis sometimes loosen, this resulting in quite a severe pounding noise when the car is operated over anything but the smoothest highway.

CHAPTER VI

THE FORD TRUCK AND TRACTOR CONVERSION SETS AND GENUINE FORD TRACTOR

Ford Truck Conversion Sets—Tractor Attachments for Ford—The Genuine Ford Tractor—Fuel Supply and Cooling System—Lubrication Simple and Positive—Simple Ignition System—Power Transmission System—Final Drive by Worm Gears—Other Ford Tractor Details—Electric Lighting and Starting System for Ford Cars.

Ford Truck Conversion Sets. — Another development worthy of mention is the large sale of adapters, special rear axles, auxiliary frames, etc., devised to transform a popular light-weight pleasure car into one-ton capacity truck. These have not been used under varying conditions long enough yet to determine their real value and influence on the depreciation of the power-producing elements of the original chassis which have not been strengthened proportionately as the load-carrying members have. These devices, which are outlined in Fig. 95, can be divided into five general classes. In the types outlined, that at A retains the Ford rear axle and spring, but the wheel base is increased by the introduction of a section in the frame at either of the two points shown, and the drive shaft is also increased in length to correspond to the increase in wheel base. The type shown at B provides for additional load capacity by the use of supplementary springs attached directly to the housings of the drive gearing actuating the steel wheel. These wheels are carried on special bearings independent of the Ford rear axle, so this member is used merely to transmit power and is not subjected to the strain of

carrying the vehicle load. In class C the rear axle is used for a jackshaft for a chain driven rear-end truck assembly, which is a unit with a supplementary frame

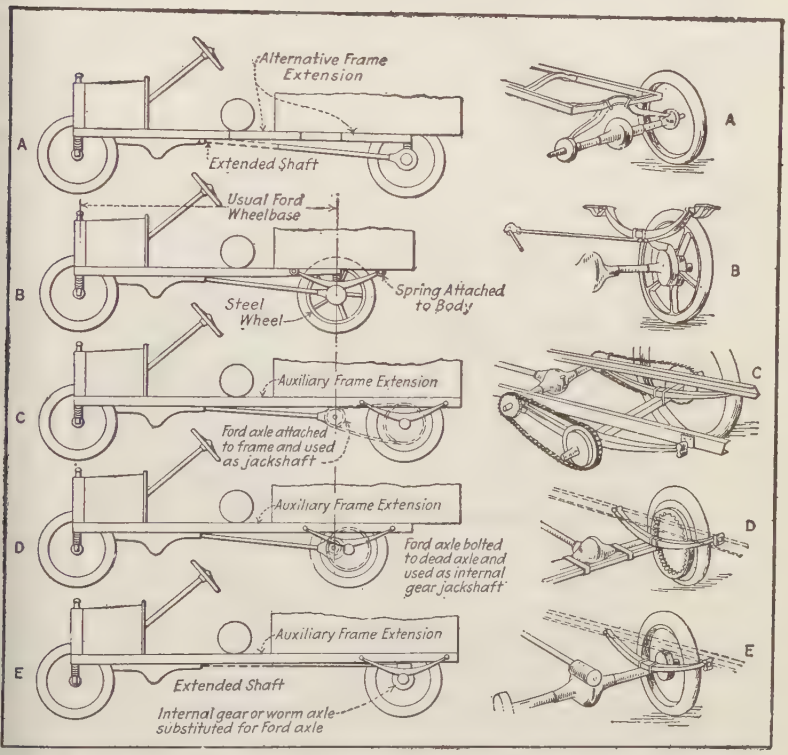


Fig. 95.—Diagrams Showing Classification of Various Conversion Sets Marketed to Convert Ford Standard Chassis to Truck Service.

extension adapted to be easily attached to the regular chassis. The design shown at D is similar, except that the rear axle is changed into a jackshaft for an internal gear-driven unit. Instead of sprockets on the axle shaft ends, as at C, spur pinions which mesh with large internal spur

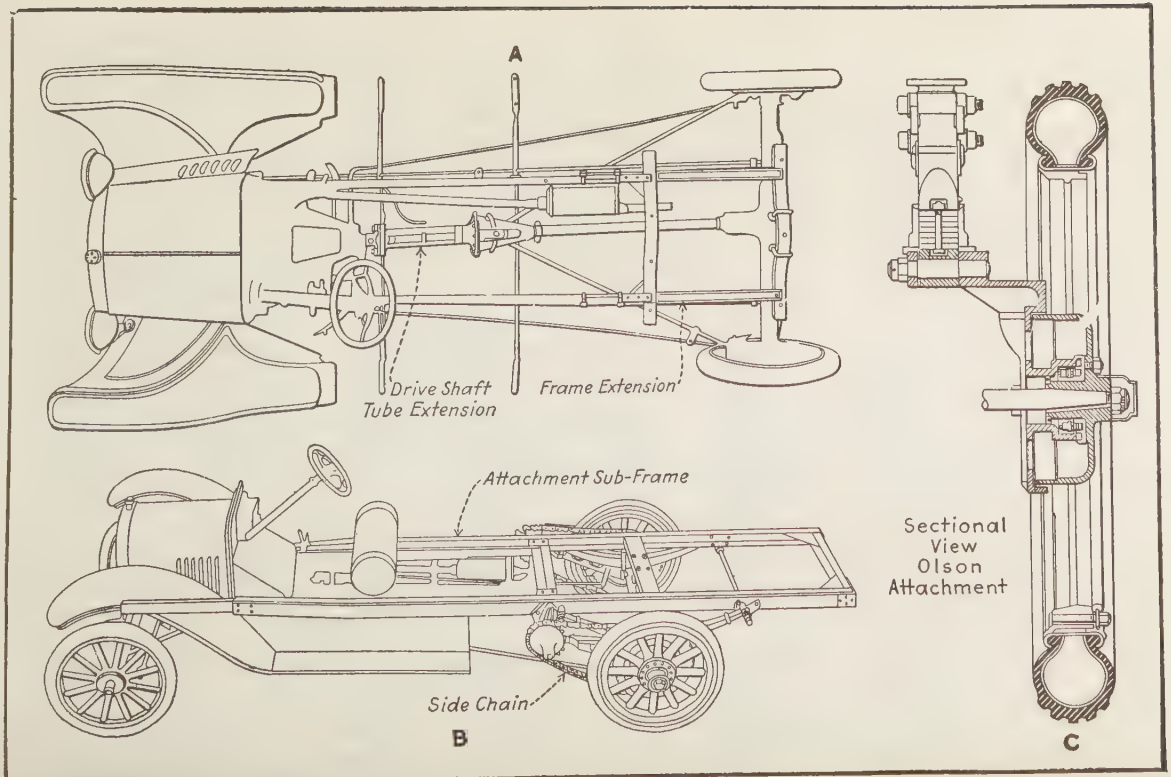


Fig. 96.—Group of Ford Truck Conversion Sets, Showing Details of Construction. A—Extended Drive Shaft

gears driving the wheels are employed. In the type shown at E, an auxiliary frame extension is used, but this carries a worm or internal gear drive axle and special wheels and springs. The Ford rear axle is not used at all, nor are the Ford rear wheels. Those types in which the load is carried on special springs and axle members, as at B, C, D, and E, are much stronger than that out-

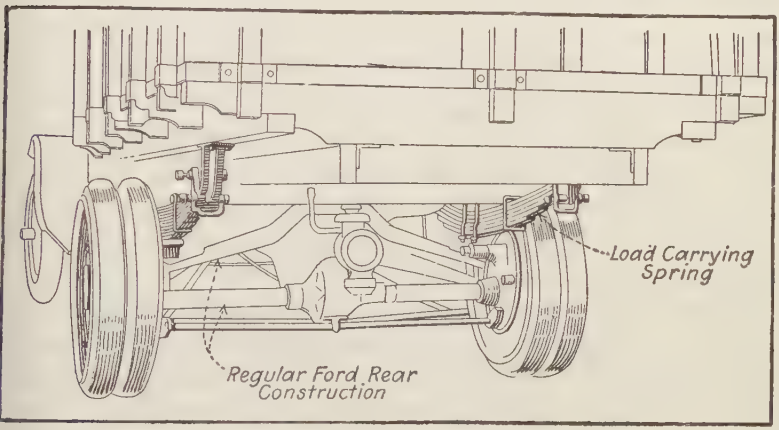


Fig. 97.—Olsen Converter Adapted to Ford Chassis.

lined at A. The regular rear end construction was never intended to carry heavy loads.

Referring to the diagrams at Fig. 95, it will be evident that a variety of conversion sets are available to change the Ford passenger car chassis to one adapted for commercial work. The actual appearance of the chassis when viewed from above and fitted with a driving shaft and frame extension installed is shown at A, Fig. 96, in which added parts are clearly outlined. The complete subframe unit and extension used in connection with side chain drive is shown at B. In this outfit, the regular

Ford rear axle is attached to the converter frame and becomes a jackshaft, the wheels being removed and replaced with sprockets for side chain drive to the solid-tired wheels of the attachment which revolve on a non-rotatable axle. The sectional view of the Olsen conversion set wheel is shown at C. With this, all of the weight is carried directly by the wheel as the end of the Ford rear construction is put into a substantial casting that converts the axle end from a simple non-floating live axle to a three-quarter floating type in which the axle drive shaft is relieved of all load except the driving strain. The method of applying the attachment is shown at Fig. 97, which shows the rear end of a converted chassis. The substantial springs to which the load-carrying body is attached and the method of supporting the weight directly on the wheels is clearly shown.

In this adapter the driving power is communicated to the rear wheels through the original Ford drive shaft, which is not altered in any way. The Ford universal joint is left in its original position, and an auxiliary drive shaft connects it to the drive shaft, which has been moved back with the axle to increase the wheel base. The original rear axle of the Ford is also used, but so changed that it carries nothing but the torque, or driving load. The rear wheels of the truck, together with their bearings, carry large semi-elliptic springs, that in turn support the truck body. By this arrangement the truck load is transferred directly to the wheels themselves.

The drive is of the internal gear type, with a small pinion mounted on the end of the Ford axle, meshing directly with a large internal gear bolted to the wheel. Ball bearings are used throughout the rear construction, and all gears are cut from steel blanks, hardened, and

the races ground to a finish. As the larger bearing, carrying the load, is of the roller type, it may be adjusted to compensate for any wear. Through the gear reduction of the internal gear drive the final gear ratio is seven to one, which is considered the best ratio for this type of equipment. Both the service and emergency brakes are mounted on the rear wheels. The original Ford service brake is removed and replaced by a new service brake

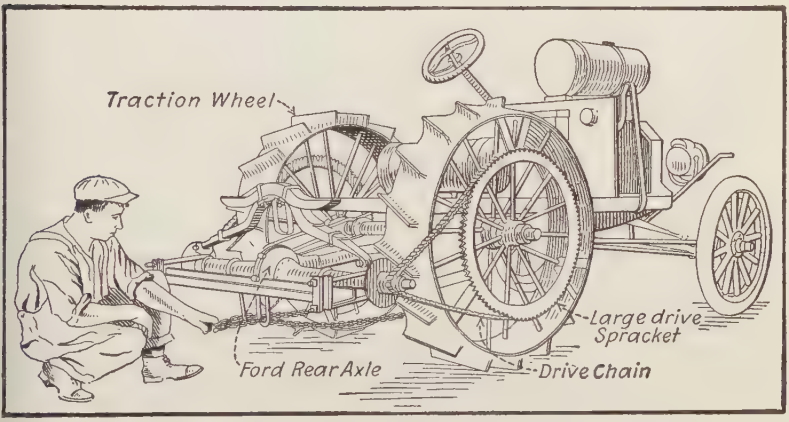


Fig. 98.—The Acason Chain Drive Tractor Attachment.

shaft and pedal, connected to a sixteen inch by two inch internal brake, the emergency brake operating through the lever as formerly. However, both the service and emergency brakes are connected, and both are applied through the lever.

Tractor Attachments for Ford.—The power and reliability of the Ford engine make it possible to use this light chassis for much heavier work than one would imagine it capable of. A variety of tractor attachments are provided by which the Ford chassis may be used for

light agricultural work that would ordinarily be done by several horses, such as plowing, harrowing, cultivating, etc. A practical attachment of this nature is shown at Fig. 98.

The drive is by chain with a pinion sprocket fitted to the ends of the ordinary Ford axle and a large ring sprocket connected to the drive wheel. The reduction between the sprocket and the drive wheel is thirty-nine to one. The starting shocks are claimed to be more easily absorbed by the use of the chain-drive, and it is claimed that the rear spring absorbs the starting torque. The load is hauled by a steel chain which is attached to the center of the Ford chassis and carried over braces which extend downward from the attachment frame. This spring drive and spring pull are claimed to be exclusive and applications for patents have been filed. It will be noted that the drawbar attachment is at the center of the converted Ford chassis, thus having the effect of holding the front wheels on the ground. It is claimed that with the lighter type of tractors it is a common failing that the front wheels are lifted from the ground due to the forces of the drive and the drawbar pull. A study of the attachment shown herewith will bring out the fact that in pulling the trailer the front wheels are held on the ground by virtue of the fact that the drawbar attachment is forward of the rear wheels, which act as a pivot point upon the ground.

The tractor is known as the Aca-tractor chain-driven unit, and the makers claim that the drive strain is distributed over several teeth in front and rear sprockets, so that breakage of a tooth in either does not put the machine out of commission. The chains used in the drive are the Diamond Roller type, one by five-eighths by five-

eighths inches. This is a self-cleaning chain due to the fact that it operates around a very narrow angle on the sprocket. The Ford rear axle is strengthened by a channel beam to prevent danger of springing. One of the advantages claimed for the unit is its short wheelbase. This is due to the fact that the drive wheels are placed in front of the Ford axle, and has the advantage of being able to make a short turn in plowing and other field operations.

Probably the greatest difficulty which Ford tractor attachments have had to contend with is in the supply of cooling water. The method used in the Aca-tractor to increase the radiator capacity is to mount above the engine a tank holding eleven gallons, making a total of sixteen gallons of water in circulation. Another provision made in meeting the troubles which beset the farm tractor is the use of the Bennett air cleaner. This is an air-washing arrangement which is in common use on tractors. By setting the drive wheels close to the frame, the front and rear wheels track in the furrow. This tends to reduce the pull in plowing. To attach the machine to the Ford chassis requires about three hours. No holes need be bored in the chassis and it is only necessary to put four clamps in place and a total of ten nuts. No changes are made in the mechanism of the Ford. With the Acason attachment a clear view of the implements is given while working in the field, and this is not the case where the body remains on the chassis.

Another conversion set for tractor work is shown at Fig. 99. This is known as the Make-a-Tractor, and while shown fitted to a Ford chassis it can be fitted to other passenger cars as well. The type shown at A is used especially on the Ford, for which it was originally de-

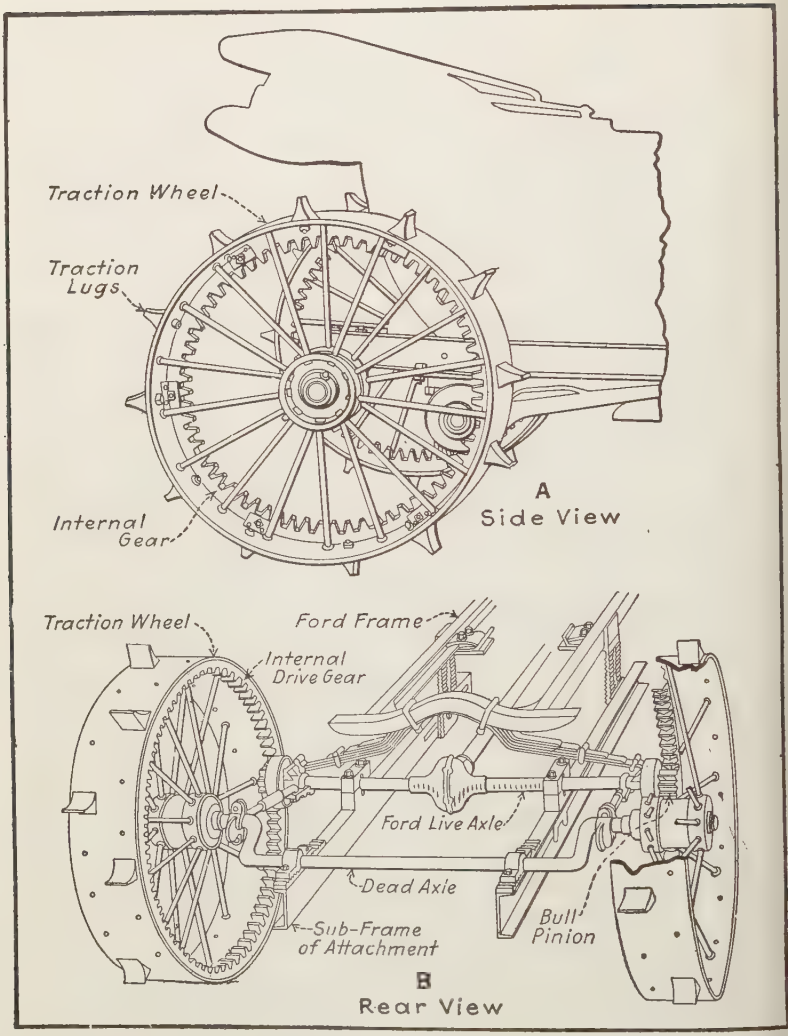


Fig. 99.—The Make-a-Tractor Attachment for Ford Cars.

signed; the form at B is the adaptable type for other cars as well as the Ford. It is claimed by the manufacturer that this device can be attached in from fifteen to twenty minutes, ready for work in the field. The various features include an auxiliary cooling system, consisting of a centrifugal pump and a specially designed fan to aid in keeping the power unit cool when working under severe conditions. A device for attachment to the carbureter to prevent dust from entering the engine also is supplied.

In mounting the attachment the rear wheels of the motor car are removed and the two driving pinions which mesh with the bull gear on the tractor wheels are attached. All implements are pulled by the attachment itself, thus relieving the chassis of the motor car as much as possible from the strain of the work. The gear reduction is eleven to one. Traction is secured by the semi-concave creepers shown in the illustration. For sandy soil special ten-inch angle creepers are supplied. The two side channels are attached to the chassis by side clamps, and slots are cut in the forward end of the channels, which allow for the spring action of the car. An attachment also is provided by which belt power can be had for various kinds of farm work. Special pinions also are provided for road work which give a speed of about 6 m.p.h. The maker states that this attachment will do the work of four to eight horses and will plow about one-third more acreage than horses.

The Genuine Ford Tractor.—A machine which is built up of a standard touring car and a tractor attachment cannot be expected to do the same kind of work that a specially designed tractor can do. The following information regarding the new tractor, which is destined to become as well known in the agricultural world as the

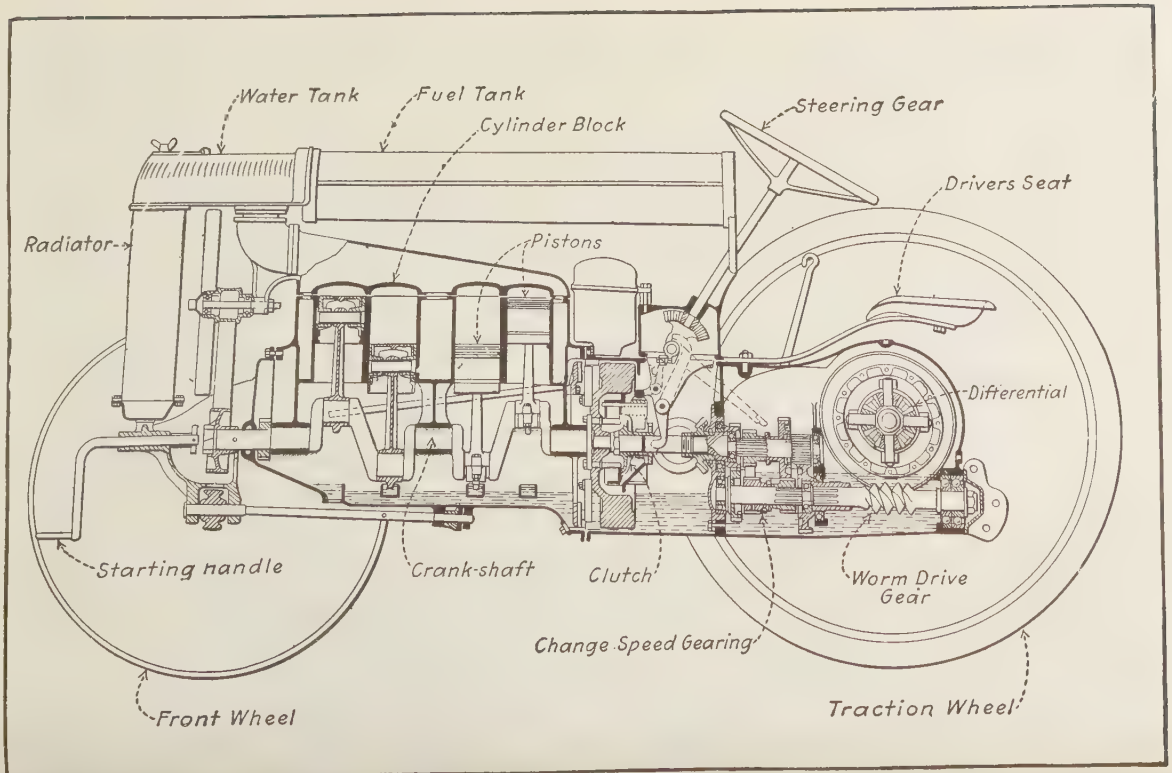


Fig. 100.—Sectional View of Henry Ford Tractor, Showing Important Parts of Mechanism.

car is, was given by Chas. E. Sorenson, the chief tractor engineer for Henry Ford, to a writer in "Motor World" from which the extracts are taken because they are authoritative and go thoroughly into detail. A sectional

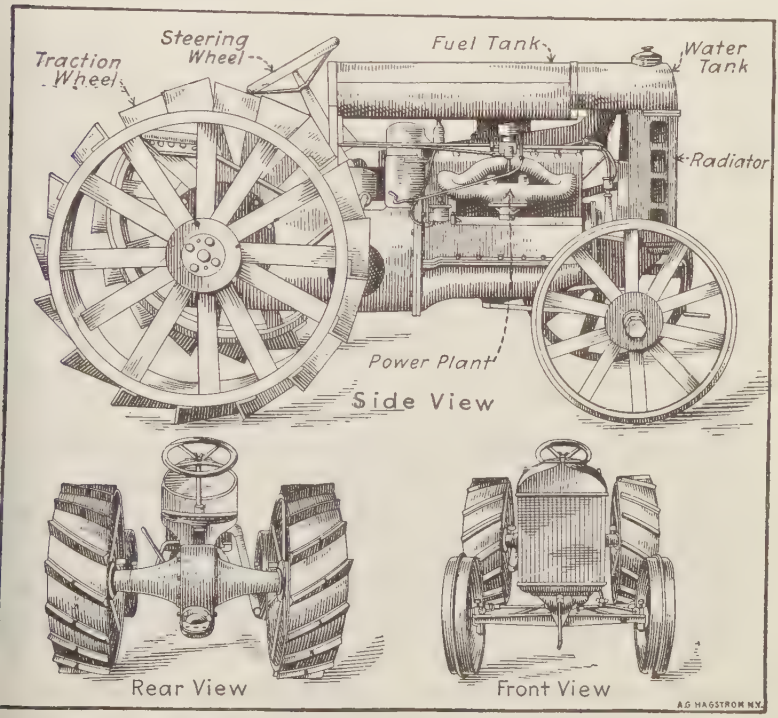


Fig. 101.—Views of Ford Tractor. At Top, Carburetor Side of Engine. Below, Rear and Front Views, Showing Simple Design.

view of the new design, showing its great simplicity is given at Fig. 100, while the views at Fig. 101, show clearly the external appearance.

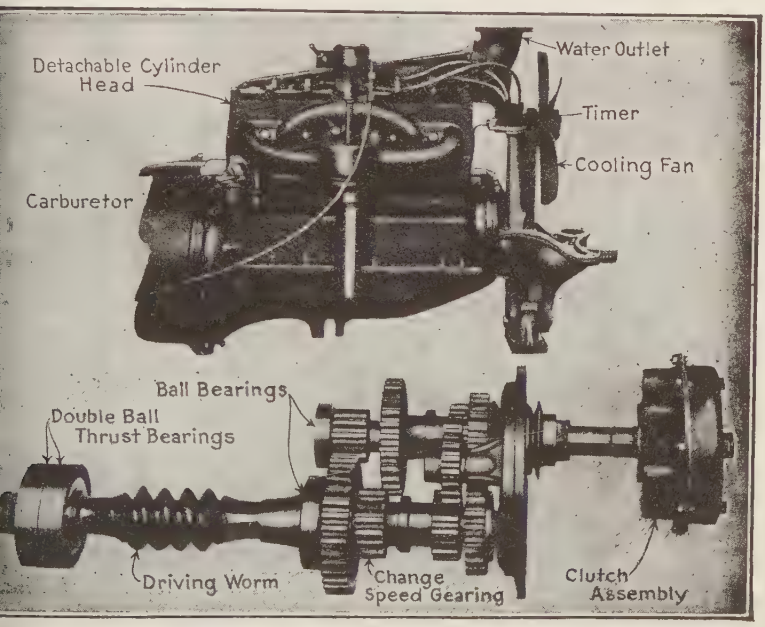
Henry Ford's tractor, which has been looked forward to with interest by every dealer of automobiles in the

farming districts of the country, is just entering production. The Ford tractor incorporates the well-known Ford idea of simplicity and accessibility, light weight and good materials. The tractor weighs twenty-five hundred pounds and will readily do the work of four horses in plowing and harvesting. In a great many instances one part has been made to do the work of two or three, and a notable instance of this is that the tractor has no frame. The housings for the engine, gearbox and rear axle not only fulfill their own functions, but act as the structural support besides. Taking the machine as a whole, it is best described as a unit construction. The power plant, transmission and rear axle housings are bolted together so as to form one solid piece, which acts as the backbone of the machine. This unit is mounted flexibly on the front axle so that no undue stresses are imposed on the running gear by irregularity of the ground.

The Ford Tractor Engine.—The engine is a four-cylinder four by five inches L-head block type, having a displacement of 251.3 cubic inches. It is capable of delivering, according to tests which have been made on the dynamometer at the plant of Henry Ford & Son, 22 h. p. at 1,000 r.p.m. This is with kerosene and at a compression of sixty pounds absolute. The working torque of the engine is fifteen hundred inch-pounds. The engine block is cast from semi-steel, in other words, from iron refined by the addition of about fifteen per cent of steel scrap. The crankcase is also of semi-steel; so are the pistons. The length of the pistons is four and seven-eighth inches, and the pressure on the piston head is transmitted through the pin bearings, which are in the bosses of the piston, to a one and three-eighth inch diameter piston pin of chrome vanadium steel. The bear-

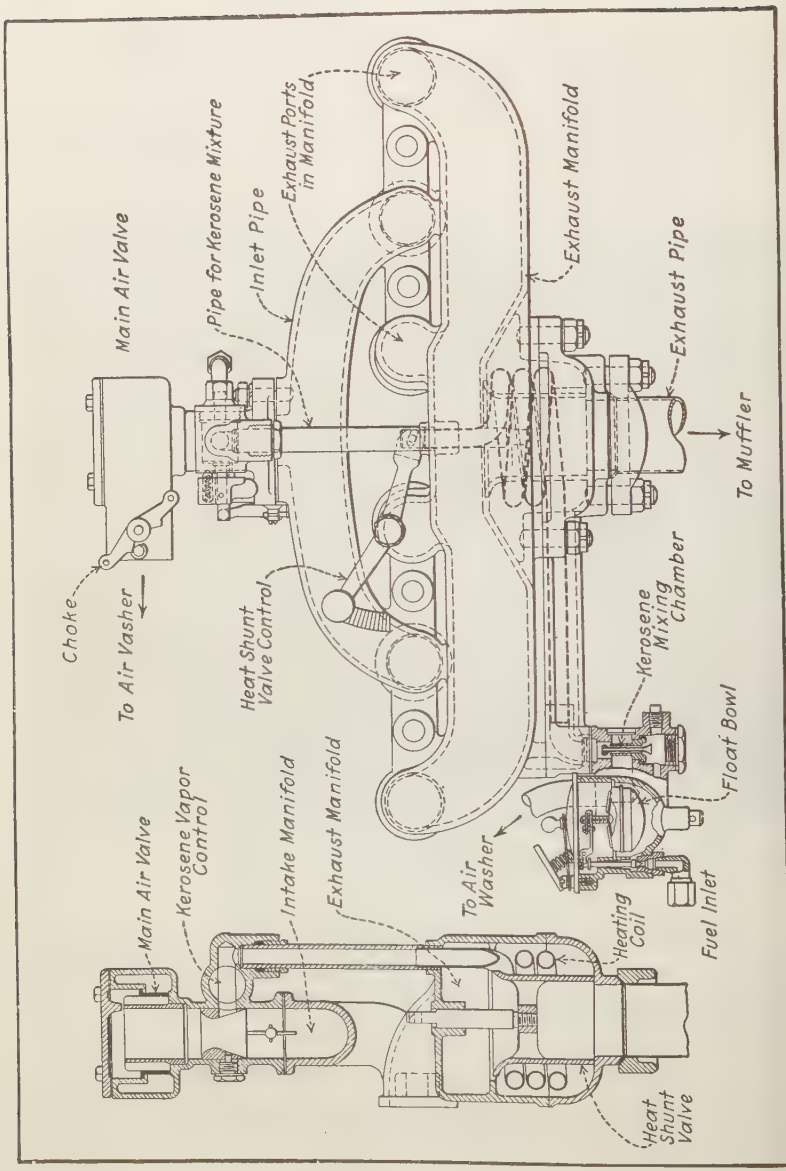
ng length on this pin is two and a quarter inches, the ins bearing directly on the cast iron of the pistons.

Three crankshaft bearings are used with interchange-ble caps. This is one of the features of the machine ending toward simplicity and making for low manufac-



ig. 102.—At Top, the Ford Tractor Engine. Below, Clutch, Gear Set, and Driving Worm.

ring cost. It also is a factor in the maintenance of the actor. All of the crankshaft bearings are two inches diameter and three and one-quarter inches long. A eel gear is carried on the end of the crankshaft and eshes with a cast-iron gear on the camshaft. These ears have helical teeth. The camshaft is carried in three earings, each one-fifteen-sixteenth inch in diameter.


Main Air Valve
Pipe for Kerosene Mixture
Inlet Pipe
Exhaust Ports in Manifold
Exhaust Manifold
Exhaust Pipe
To Muffler
Choke
To Air Vasher
Heat Shunt Valve Control
Kerosene Mixing Chamber
Float Bowl
Fuel Inlet
Heating Coil
To Air Washer
Main Air Valve
Kerosene Vapor Control
Intake Manifold
Exhaust Manifold
Heat Shunt Valve

The lengths of front, center and rear bearings are two and three-quarters, two and one-half and one one-half respectively. The cams are forged integral with the camshaft and operate directly on mushroom tappets. No adjustment is provided between the push rod and the valve stem, the poppet valves being operated directly. These valves have a clear diameter of one and one-half inches and a lift of five-sixths of an inch. The valve timing is as follows: Intake opens ten degrees after top center and closes forty degrees after bottom center; exhaust opens forty-five degrees ahead of bottom center and closes on top center.

Fuel Supply and Cooling System.—Fuel is carried in an overhead kerosene tank having a capacity of twenty-one and one-half gallons, which is carried by supports above the engine. For starting, gasoline is used and a gasoline tank holding about one quart is provided. The vaporizing system consists of a single bowl carbureter in connection with the vaporizing manifold, in which the intake passes through a coil surrounded by the exhaust gases. All the air passes through an air-washing device filled with water. First the kerosene is sprayed into the primary air and after this mixture has been completely vaporized in the coil, the secondary air is added at a point above the coil. A distinctive feature is the use of a damper on the manifold for controlling the amount of heat reaching the coil. Sectional views at Fig. 103 clearly show the interior construction of the Ford Tractor Carbureter, and its action can be easily understood by comparing its construction with the description previously given, as all parts are marked on the drawing.

One of the problems that have been given the most thorough study in the design of this tractor is that of

cooling. In line with the decision to produce a tractor of the utmost simplicity neither a water pump nor an oil pump has been provided. The thermo-syphon system of cooling water circulation is used, the quantity of water carried being eleven gallons. There are certain distinctive features in this thermo-syphon system. In the first place the water jackets extend the entire length of the cylinder down to the crankcase flange. No rubber hose connection is used between the radiator and engine, the two being bolted together. The radiator is of the flange tube type having an eighteen by twenty inch core with a depth of four inches. Cooling is aided by a four-blade seventeen inch fan operated by a two-inch flat belt on cast iron pulleys at the end of crankshaft and on the fanshaft. The fan runs on ball bearings.

Lubrication Simple and Positive.—Oiling is by constant level splash, the flywheel magnets being used as a distributer. The oil caught up by these magnets is thrown into a scoop at the end of an oil pipe which leads to the front of the crankcase. Here the oil overflows to troughs beneath each of the four connecting-rods. The passage of the connecting-rod spoons into these troughs of oil throws up a spray which lubricates the entire interior of the engine, including the main bearings and timing gears. No attention need be given the oiling system, except to see that it is supplied with lubricant. The capacity of the system is two and one-half gallons.

Simple Ignition System.—Ignition is by flywheel magneto. There are ten magnets clamped to the flywheel which rotate behind the stationary armature. The voltage of the magneto varies with the speed of the engine from six to fourteen volts, a hotter spark being produced at higher speeds. The voltage is close to fourteen a

1,000 r.p.m. The current generated is delivered to a single induction coil. The breaker mechanism is incorporated with the distributer, the combined instrument being mounted on a vertical distributer shaft driven through miter gears from the camshaft. The timer can be easily distinguished on the side of the engine at Fig. 102.

Power Transmission System.—From the engine, the drive is transmitted through a multiple disc clutch running in oil. There are seventeen tempered steel discs in this clutch, which have an effective face width of one and one-sixteenth inch. The outside diameter of the discs is seven inches, and they are held in engagement by six eighty-pound springs, giving a total pressure of four hundred and eighty pounds.

The clutchshaft or driveshaft is supported by a pilot bearing at the rear end of the crankshaft and carries the constant mesh gear for the three-speed gearbox. This is on the upper shaft of the gearbox, and the lower shaft is direct-connected to the worm which provides the final drive. By means of the combination of the reductions in the gearbox and in the worm gear, which latter has a ratio of 17.5:1, the following total reductions are obtained:

Gear	Ratio	Miles per Hour at 1,000 r.p.m. of Crankshaft
High	18.25-1	6.83
Low	85 -1	1.34
Reverse	48 -1	2.60
Plowing (intermediate)	46 -1	2.70

All the gears and shafts of the transmission set are of chrome vanadium steel, and the shafts are carried on

ball bearings of a type capable of taking both radial and thrust loads of considerable magnitude. The power transmission system can be readily traced in the sectional view, Fig. 100, which clearly shows the relation of the various parts, lettered for easy identification. This view also shows the worm gear final drive. The photograph of the power transmission parts given at Fig. 102, also assists in securing an understanding of the transmission system.

Final Drive by Worm Gears.—The worm gear is of the undemountable type. It comprises a sixty degree double thread straight worm having a pitch of one and two tenth inches. At the rear end the worm shaft is supported in a duplex radial and thrust bearing. The worm is made of chrome vanadium steel and the worm wheel of aluminum bronze, which is composed of ten per cent aluminum and ninety per cent copper.

The worm wheel is secured to the differential housing by twelve bolts. The differential, which is a four pinion type, transmits the drive to the semi-floating axle. The driving wheels are mounted on the shaft by means of a slotted tapered hub filling provided with a flange drilled for four heavy cap screws. The hub piece is splined at the axle connection to render the transmission of the driving torque more secure.

Other Ford Tractor Details. — Steering is through bevel gear sector and pinion, with a ball-end drop arm connecting through a large rod to the front axle cross arm. The steering reduction between the pinion and sector is 3.50 to 1; and an eighteen-inch hand wheel is mounted on the one inch column.

The driving wheels are forty-two inches in diameter and are provided with suitable traction lugs on the rim

The best shape of the lugs is one of the details which is engaging the attention of the engineers at present, a self-cleaning lug being the object in view. The wheel rim

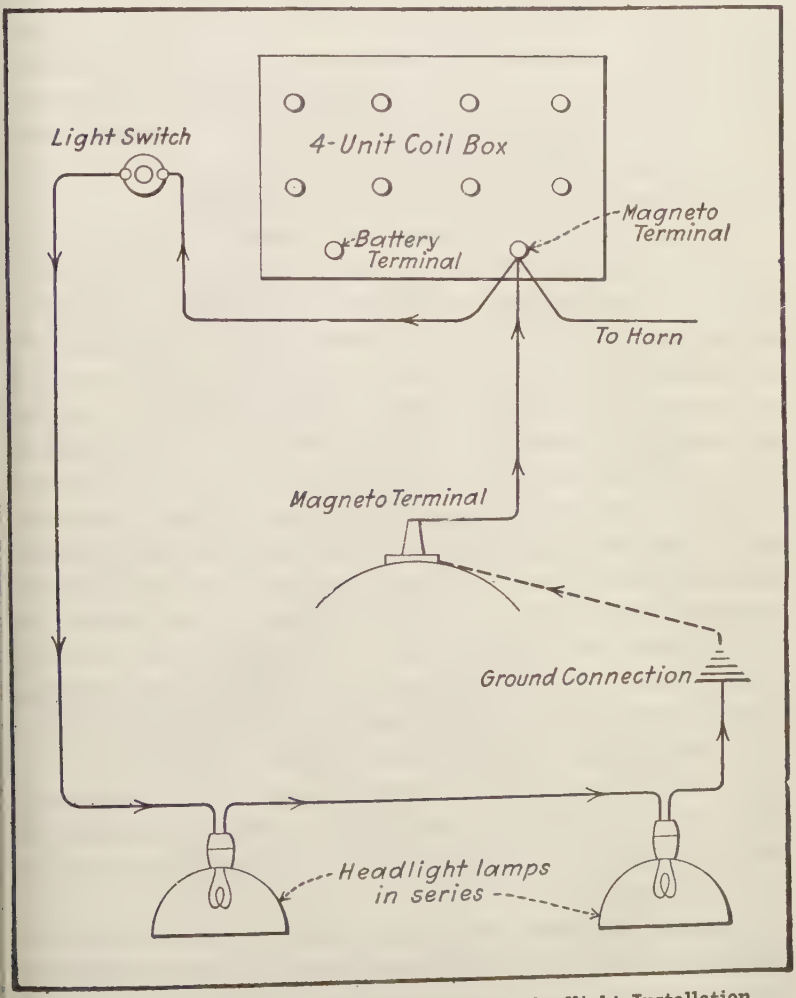


Fig. 104.—Wiring System of Ford Electric Headlight Installation.

is made of hot rolled steel. The front wheels are also of hot rolled steel and are of built-up T section, the spoke being riveted between two angle irons placed back to back, with the flange projecting outward to serve as a skid ring. The diameter of the wheel proper is twenty-eight inches, but the total diameter over the skid ring is thirty inches. The front axle is an I-section forging, this design having replaced the three piece built-up construction formerly employed. The wheels are carried on combined radial and thrust ball bearings.

One of the points which have been borne in mind in laying out this tractor is the fact that the farmer, usually a man of little mechanical experience, will have to take care of it. Everything can be reached with comparatively little effort. For instance, the crankcase can be dropped while the tractor is standing on its wheels, the only part needing to be removed being the radius rod. The tractor is able to turn in a radius of twenty-one feet, and can work steadily under a fifteen hundred pound drawbar pull or a two-plow load, on the plowing (intermediate) gear, which still leaves a twenty-five per cent reserve of power. The hard ground road clearance of the tractor is eleven inches. The lowest point of the tractor being the flywheel housing. On medium ground where the vertical flange of the front wheel will sink into the surface, the clearance is ten inches.

The machine is very easily handled and controlled and as it is simple in construction it can be repaired by any mechanic of ordinary skill, making it of special value to the farmer.

Electric Lighting and Starting System for Ford Cars.—The first model T cars were equipped with acetylene generator and gas headlights. In 1916 models, electric

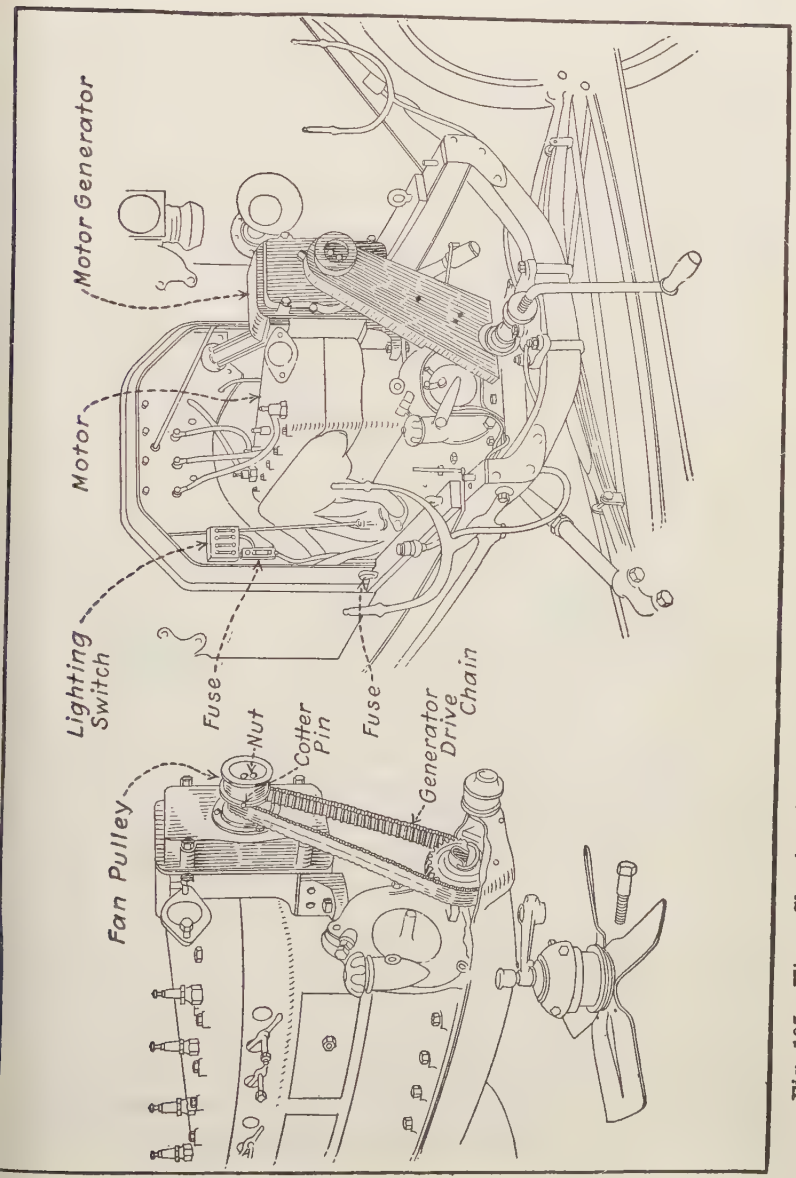


Fig. 105.—Views Showing Application of Self-Starting Motor-Generator to Ford Car Engine.

lights were installed, the current being taken from the flywheel magneto, the magnets being made larger for this purpose. The wiring diagram for the regular Ford lighting system is given at Fig. 104. It will be seen that the

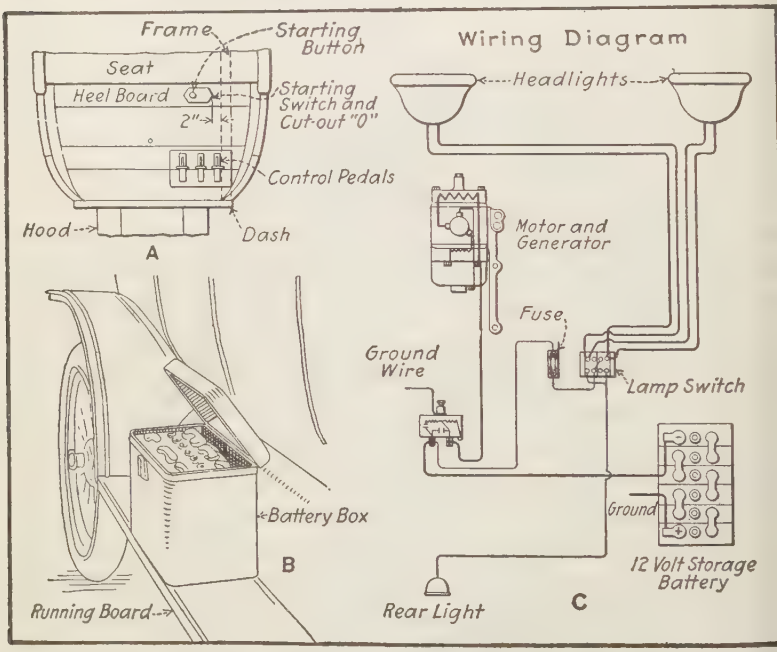


Fig. 106.—Details of Starting System Installation, also Showing Wiring Diagram.

headlight lamps are in series and that but one wire is needed for the entire system.

There is a demand for self-starting systems of the electrical type, and when such a system is provided it is possible to use electric side lights and tail lights as well as headlights. In the regular Ford lighting system the lamps go out when the engine is stopped and burn dimly

when the engine runs slowly. Because of this, the side lamps and tail lamp burn kerosene oil.

When a starting system is fitted, a storage battery is installed and lights may be had regardless of the engine speed. There is no fluctuation of light with varying engine speeds. A variety of simple starting and lighting systems have been designed especially for Ford cars. The combined generator and motor shown at Fig. 105 is easily installed, and is driven by a silent chain. When the engine turns the dynamo, it generates current which goes to the battery. When the engine is stopped, the current from the battery may be turned on to make the electrical machine a motor, and turn over the engine. Details of the system are given at Fig. 106, also a complete wiring diagram for those who desire to study it. The only drawback to such systems is their cost, as they involve an expenditure of nearly one-third the cost of the entire car.

Ford F. A. Lighting and Starting System.—The starting and lighting system on 1919 and 1920 Fords is of the two-unit type and consists of the starting motor, generator, storage battery, charging indicator, and lights, together with the necessary wiring and connections as clearly shown at Fig. 107. The starting motor is mounted on the left-hand side of the engine and bolted to the transmission cover. When in operation the pinion on the Bendix drive shaft engages with the teeth on the flywheel. The location is clearly shown at Fig. 108.

The spark and throttle levers should be placed in the same position on the quadrant as when cranking by hand, and the ignition switch turned on. Current from either battery or magneto may be used for ignition. When starting, especially if the engine is cold, the igni-

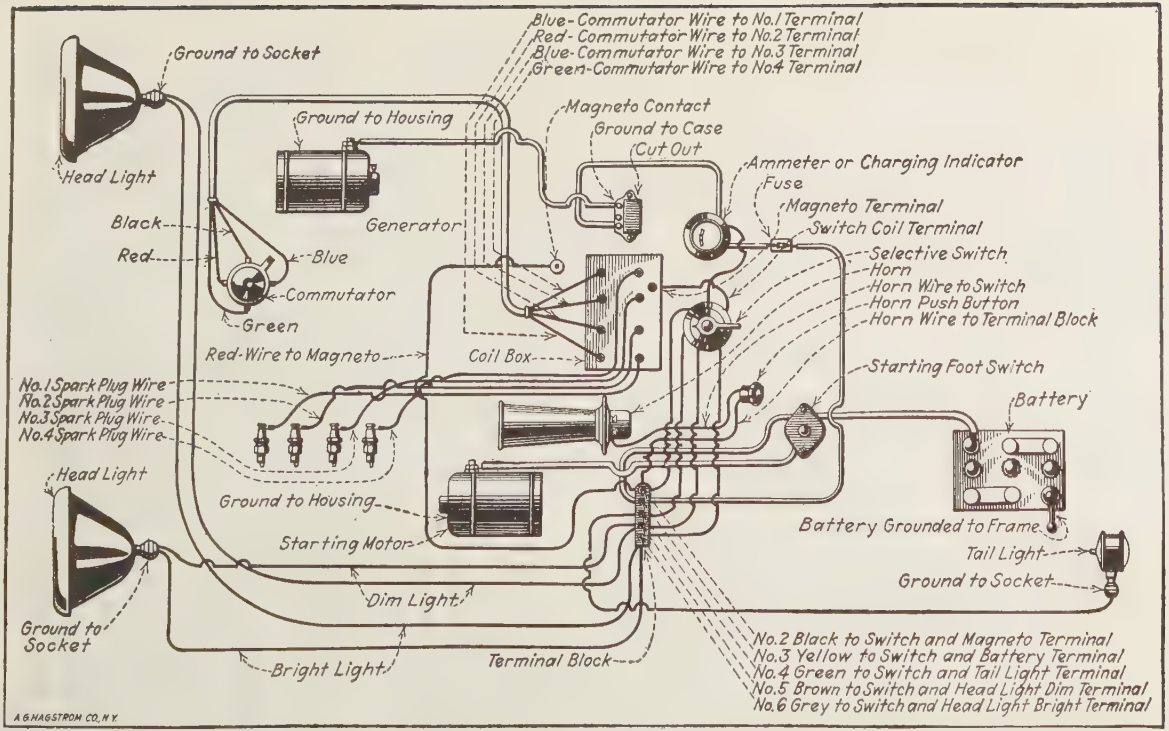


Fig. 107.—Starting and Lighting System Used on 1918 Closed Body Ford Cars and on 1919-20 Models of All Types Showing Method of Wiring Various Units of the Ignition System as Well as Those Used for Engine Starting and Lighting.

tion switch should be turned to "battery." As soon as the engine is warmed up, turn switch back to "magneto." The magneto was designed to furnish ignition for the Model T engine and better results are obtained if attention is paid to the position of the spark lever, as a too advanced spark will cause serious backfiring which in turn will bend or break the shaft in the starter.

How System Operates.—The starting motor is operated by a push button, conveniently located in the floor of the car at the driver's feet. With the spark and throttle levers in the proper position, and the ignition switch turned on, press on the push button with the foot. This closes the circuit between the battery and starting motor, causing the pinion of the Bendix drive shaft to engage with the teeth on the flywheel, thus turning over the crank shaft.

When the engine is cold it may be necessary to prime it by pulling out the carburetor priming rod, which is located on the instrument board. In order to avoid flooding the engine with an over-rich mixture of gas the priming rod should only be held out for a few seconds at a time.

When Engine Does Not Start.—If the starting motor is turning the crank shaft over and the engine fails to start, the trouble is not in the starting system. In this event release the button at once, so as not to unnecessarily discharge the battery, and inspect the carburetor and ignition system to determine the trouble.

If the starting motor fails to act after pushing the button first inspect the terminal on the starting motor, the two terminals on the battery and the two terminals on starting switch, making sure all of the connections are tight; then examine the wiring for a break in the insula-

tion that would cause a short-circuit. If the wiring and connections are O. K. and the starting motor fails to act test the battery with a hydrometer. If the hydrometer reading is less than 1.225 the trouble is no doubt due to a weak or discharged battery.

How Generator Operates.—The generator is mounted on the right-hand side of the engine and bolted to the cylinder front end cover. It is operated by the pinion

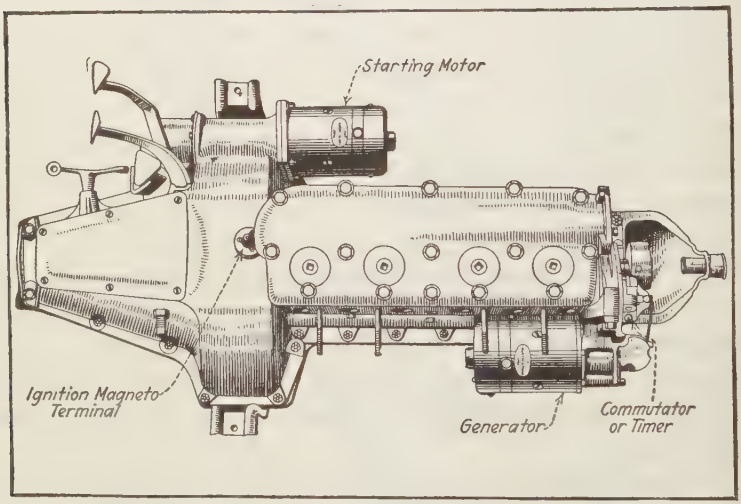


Fig. 108.—Top View of Ford Model T Motor Showing Starting Moto and Generator Location Relative to Engine Parts.

on the armature shaft engaging with the large time gear The charging rate of generator is set so as to cut in a engine speeds corresponding to 10 miles per hour i high speed and reaches a maximum charging rate of 2 miles per hour. At higher speeds the charge will tape off, which is a settled characteristic of battery charging This operation of cutting in and cutting out at suitabl speeds is accomplished by the cut-out, which is se

properly at the factory and should not under any circumstances be tampered with.

Lubrication of Units.—The starting motor is lubricated by the Ford splash system, the same as the engine and transmission. The generator is lubricated by a splash of oil from the time gears. In addition an oil cup is located at the end of the generator housing and a few drops of oil should be applied occasionally.

The introduction of a battery current into the ignition magneto will discharge the magnets and whenever repairing the ignition system or tampering with the wiring in any way, do not fail to disconnect the positive wire from the battery. The end of this wire should be wound with tape to prevent its coming in contact with ignition system or metal parts of the car.

Functions of Charging Indicator.—The charging indicator is located on the instrument board. This indicator registers "charge" when the generator is charging the battery and "discharge" when the lights are burning and the engine not running above 10 miles per hour. At an engine speed of 15 miles per hour or more the indicator should show a reading of from 10 to 12 even with the lights burning. If the engine is running above 15 miles per hour and the indicator does not show "charge," first inspect the terminal posts on the indicator, making sure that the connections are tight, then disconnect the wire from the terminal or generator and with the engine running at a moderate speed, take a pair of pliers or a screw-driver and short-circuit the terminal stud on the generator to the generator housing. If the generator is O. K. a good live spark will be noted. (Do not run the engine any longer than is necessary with the terminal wire disconnected.) Next inspect the wire from the

generator, through the charging indicator, to the battery for a break in the insulation that would result in short-circuit.

The F. A. Lighting System.—The lighting system consists of two 2-bulb headlights and a tail light, operated by a combination lighting and ignition switch located on the instrument board. The large bulbs are of 6-8 volt 17 candle-power type. The small bulbs of 6-8 volt two candle-power type. The small bulb is also used in the tail light. All of the lamps are connected in parallel so that the burning out or removal of any one of them will not affect the other.

Current for the lamps is supplied by the battery. Do not connect the lights to the magneto, as it will result in burning out the bulb and might discharge the magnets. The illustration at Fig. 107 shows the different circuits and the course of the current.

If either the starter or generator fails to give proper service the owner should at once consult an authorized Ford dealer. If the trouble is not found in the wiring, connections, etc., as outlined, the dealer will remove the starter or generator, or both if necessary, and return them intact to the nearest branch for repair or replacement. Dealers or owners should not attempt to repair or tamper in any way with the windings or internal mechanism of the starter and generator. This work can only be done by competent electricians.

How to Remove Starting Motor.—When removing the starter to replace transmission bands or for any other reason, first remove the engine pan on the left-hand side of the engine and with a screw-driver remove the four small screws holding the shifter cover to the transmis-

sion cover. Upon removing cover and gasket, turn the Bendix drive shaft around so that the set screw on the end of the shaft, as shown in Fig. 109, is in the position shown. Immediately under the set screw is placed a lock washer, designed with lips or extensions opposite each other on the outside diameter. One of these is turned against the collar and the other is turned up against the side screw head. Bend back the lip which

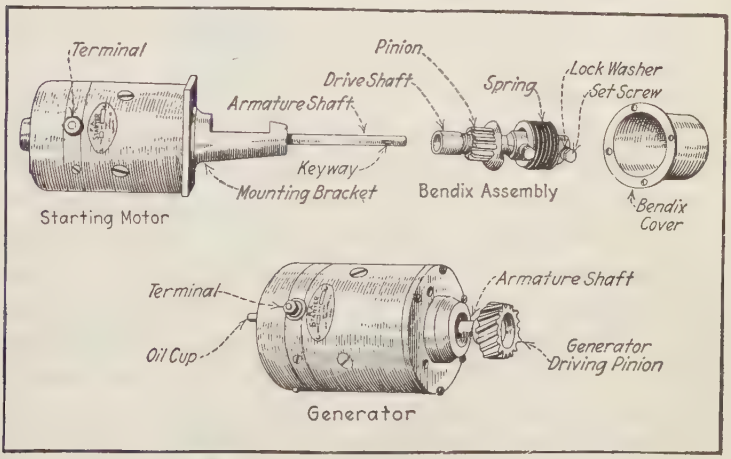


Fig. 109.—Starting Motor with Bendix Automatic Pinion Shift and Generator of Ford Starting System

has been forced against the side of the screw and remove the set screw. As the lock washer will no doubt be broken or weakened in removing the starter, a new one must be used when replacing it. These washers may be obtained from the nearest branch. Next, pull the Bendix assembly out of the housing, being careful that the small key is not misplaced or lost. Remove the four screws which hold the starter housing to the trans-

mission cover, and pull out the starter, taking same down through the chassis frame, which explains why it was necessary to remove the engine pan.

Extreme care should be used in removing the Bendix drive and other parts that none is misplaced nor lost and that they are replaced in their former position. In replacing the starter, be sure that the terminal connection is placed at the top. If the car is to be operated with the starter removed, be sure to put the transmission cover plate in position. These plates may also be obtained from the nearest branch.

How to Remove Generator.—If it is found necessary to remove the generator, first take out the three cap screws holding it to the front end cover and by placing the point of screw-driver between the generator and front end cover, the generator may be forced off the engine assembly. Always start at the top of the generator and force it backward and downward at the same time. Plates may be obtained from the nearest branch to place over the time gear if the car is to be operated with the generator removed.

Ground Generator if Battery Is Removed.—If for any reason the engine is run with the generator disconnected from the battery as on a block test, or when battery has been removed for repair or recharging, be sure that the generator is grounded to engine by running a wire from the terminal on generator to one of the valve cover stud nuts. A piece of wire 1/16″ or more in diameter may be used for this purpose. Be sure that the connections at both ends of the wire are tight. Failure to do this when running the engine with the generator disconnected from the battery will result in serious injury to the generator.

Care of Storage Battery.—Keep battery securely fastened in place. Keep battery and interior of battery compartment wiped clean and dry. Do not permit an open flame near the battery.

Keep all small articles, especially of metal, out of and

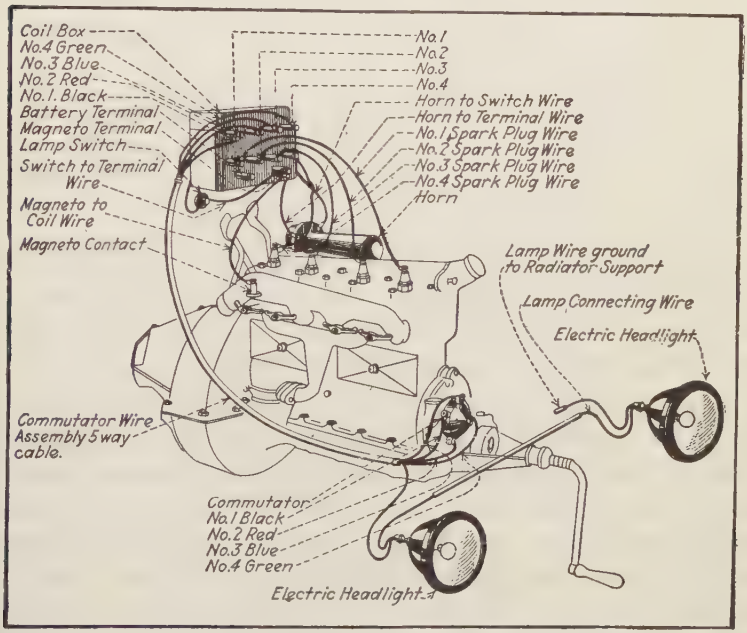


Fig. 110.—How Lamps are Wired When Current from Ignition Magneto is Taken for Bulbs.

away from the battery. Keep terminals and connections coated with vaseline or grease. If solution has slopped over or spilled, wipe off with waste wet with ammonia. A sectional view of a typical storage battery of "Exide" design is shown at Fig. 111.

Pure water must be added to all cells regularly and at sufficiently frequent intervals to keep the solution at

the proper height. Add water until solution is one-quarter inch above plates. Never let solution get below top of plates. Plugs must be removed to add water; then replaced and screwed in after filling.

The battery should preferably be inspected and water renewed once every week in warm weather, as evaporation is rapid, and once every two weeks in cold weather when evaporation is less.

Do not use acid or electrolyte, only pure water. Do not use water known to contain even small quantities of salts or iron of any kind, as such impurities will injure the battery when present in the electrolyte.

Distilled water, or fresh clean rain-water are recommended. Use only a clean glass vessel for handling or storing water. Add water regularly although the battery may seem to work all right without it.

The best way to ascertain the condition of the battery is to test the specific gravity (density) of the solution in all cells with a hydrometer. This should be done regularly as shown at Fig. 112. A convenient time is when adding water but the reading should be taken before rather than after adding the water. A reliable specific gravity test cannot be made after adding water and before it has been mixed by charging the battery or by running the car.

Use of Hydrometer.—To take a reading, use a battery hydrometer. Insert the end of the rubber tube in the cell. Squeeze and then slowly release the rubber bulb, drawing up electrolyte from the cell until the hydrometer floats. The reading on the graduated stem of the hydrometer is at the point where it emerges from the sur-

face of the electrolyte. Replace electrolyte in cell from which it has been removed.

The gravity reading is expressed in points; thus the difference between 1.275 and 1.300 is 25 points. When all cells are in good order, the gravity will test about

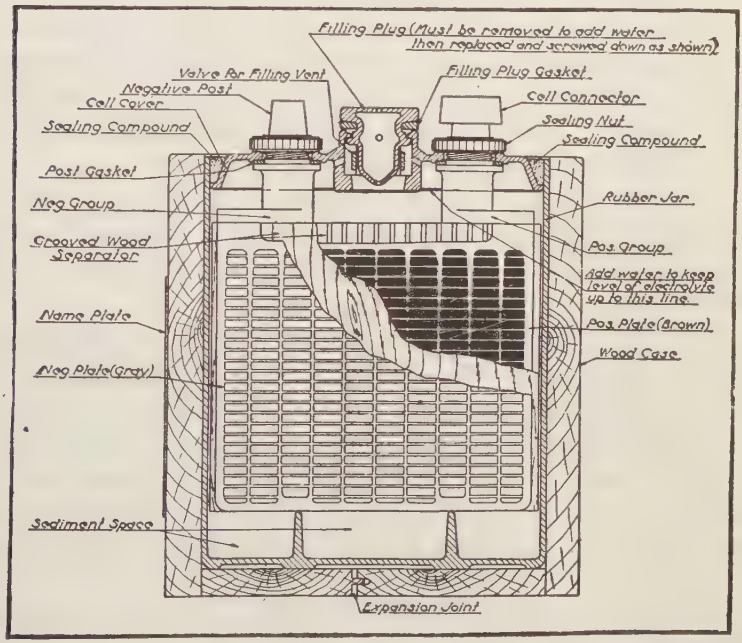


Fig. 111.—Sectional View of a Typical "Exide" Storage Battery Showing Internal Construction.

the same (within 25 points) in all. Gravity above 1.200 indicates battery more than half charged.

Gravity below 1.200 but above 1.150 indicates battery less than half charged. When the battery is found to be half discharged use the lamps sparingly until the gravity is restored to at least 1.250. If by using the

lamps sparingly battery does not come back to condition there is trouble in the wiring generator system or in the battery itself, which should be investigated and remedied immediately.

Gravity below 1.150 indicates battery completely discharged or "run down." A run-down battery should be given a full charge at once. A run-down battery is always the result of lack of charge or waste of current. If, after having been fully charged, the battery soon runs down again there is trouble somewhere in the system, which should be located and corrected.

Putting acid or electrolyte into the cells to bring up specific gravity can do no good and may do great harm. Acid or electrolyte should never be put into the battery except by an experienced battery man.

Gravity in one cell markedly lower than in the others, especially if successive readings show the difference to be increasing, indicates that the cell is not in good order.

If one of the three cells regularly requires more water than the others, thus lowering the gravity, a leaky jar is indicated. Even a slow leak will rob a cell of all its electrolyte in time and a leaky jar should immediately be replaced with a good one.

If there is no leak and if the gravity is, or becomes, 50 to 75 points below that in the other cells a partial short circuit or other trouble within the cell is indicated. A partial short circuit may, if neglected, seriously injure the battery and should receive the prompt attention of a good battery repair-man.

A battery charge is complete when, with charging current flowing at the finish rate given on the name plate, all cells are gasing (bubbling) freely and evenly and the gravity of all cells has shown no further rise during one

hour. The gravity of the solution in cells fully charged as above is between 1.275 and 1.300.

If for any reason an extra charge is needed it may be accomplished by running the engine idle, or using direct current from an outside source through lamp resistance or alternating current through a rectifier.

Charging from Outside Sources.—In charging from an

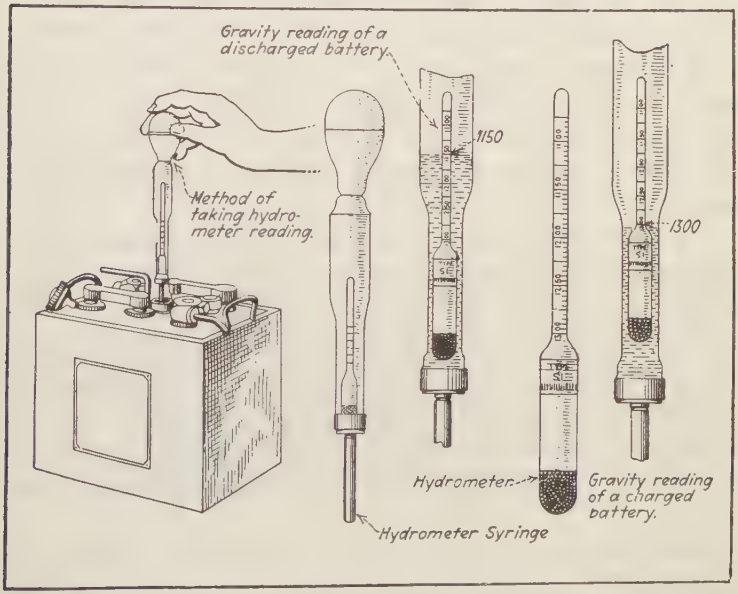


Fig. 112.—How to Take a Gravity Reading of the Electrolyte with a Hydrometer Syringe.

outside source use direct current only to the battery. Limit the current to the proper rate in amperes by connecting a suitable resistance in series with the battery. Incandescent lamps are convenient for this purpose.

Connect the positive battery terminal (with post

marked x) to the positive charging wire and negative to negative. If reversed, serious injury may result. Test charging wires for positive and negative with a voltmeter or by dipping the ends in a glass of water containing a few drops of electrolyte, when bubbles will form on the negative wire.

The normal charging rates for the various types of batteries are given on the name plate on the battery. When charging start at the starting rate and continue the charge for 6 hours at the finish rate. The specific gravity does not reach the point between 1.275 and 1.300 until battery is fully charged. If the specific gravity stops rising, it is an indication that the battery is fully charged.

If a battery has been neglected and has had little or no charging for a long period it may take several days' continuous charging to bring it up to capacity.

A battery which is to stand idle should first be fully charged. A battery not in active service may be kept in condition for use by giving it a freshening charge at least once a month but should preferably also be given a thorough charge after an idle period before it is replaced in service.

This charging can be done by running the engine until the specific gravity shows that the battery is fully charged. If this is not convenient the charging can be done by means of a rectifier where alternating current is available, or by means of a lamp resistance where direct current is available.

Winter Care of Storage Battery.—The next best thing to do is to remove the battery from the car and take it to a garage which makes a business of recharging batteries and have it charged at least once a month.

Disconnect the leads from a battery that is not in service so that it may not discharge through any slight leak in car wiring.

In order to avoid freezing of the battery it should always be kept in a fully charged condition, as a fully charged battery will not freeze in temperatures ordinarily encountered.

Electrolyte will freeze as follows:

Sp. Gr. 1.120, battery empty, 20 degrees above zero F.

Sp. Gr. 1.160, battery ¾ discharged, zero F.

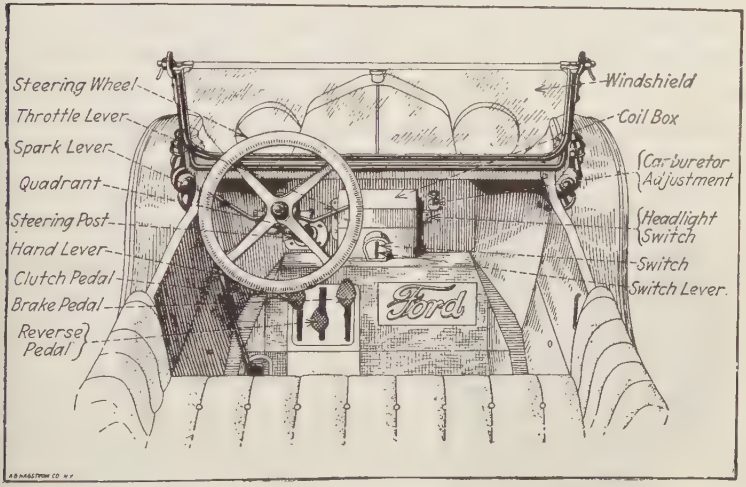


Fig. 113.—Control of 1919-20 Ford Model T Showing Headlight Switch.

Sp. Gr. 1.210, battery ½ discharged, 20 degrees below zero F.

Sp. Gr. 1.260, battery ¼ discharged, 60 degrees below zero F.

When a battery is stored away for the winter care should therefore be taken that the battery is either stored in a place where the temperature is known not to go be-

low 20 degrees above zero or the battery should at all times be kept in a fully charged condition.

The battery used in the Ford Starting and Lighting system is the six volt, 13 plate "Exide," known as type 3-XC-13-1, and in writing to the manufacturers, the Electric Storage Battery Company, Philadelphia, Pa., this identification should be given. Purchasers of cars equipped with "Exide" batteries may have their batteries tested free of charge at any service station handling these batteries and in case of doubt regarding proper functioning, the reader is advised to have the battery inspected by experts. The instructions given above are for the guidance of those having sufficient mechanical ability to care for their batteries intelligently or for operators of Ford cars in localities remote from service stations.

Fig. 113-A. Magnetometer for Ford Magneto Strength Testing.

The Magnetometer and Its Use.—The Magnetometer for Ford cars, shown at Fig. 113-A, is a rugged little instrument two inches in diameter, and is designed to be fastened to the dashboard and connected permanently to the magneto so that it will indicate at all times just what the magneto is doing. After an exhaustive series of tests made on Model T Fords of all ages and conditions, it was found that almost invariably there was a point at which the magneto, although generating, did not satisfactorily ignite the charge at all times. This point is indicated on the scale as "P"—meaning Poor. At

still another point the magneto while operating without skipping ignited the charge so slowly that there was an appreciable lack of power. This we indicated on the scale as "M"—meaning Medium. The lowest point at which efficient ignition took place was designated "G" for Good, and Excellent is indicated by the letter "E."

The Magnetometer should be located at a point on the dashboard where it can be most conveniently observed by the driver, at the same time being careful to choose a point where the terminals will extend through the dashboard under the hood, rather than above it. Drill two 3/16 inch holes in the dashboard for the studs and secure the Magnetometer in position by means of one nut and washer on each stud. Attach a cable to each stud by means of the remaining nuts and washers furnished with the Magnetometer and connect one cable to the insulated plug in the top of the magneto which carries the current to coil. The other cable from the Magnetometer should be securely grounded to the transmission case. As one side of the magneto is grounded, care should be taken to see that the Magnetometer case is not in contact with any of the metal parts of the car as that would cause trouble.

After installing, the operator should make a note of its readings at various speeds as shown by the speedometer for future reference and then by occasionally comparing the readings of the Magnetometer with the speedometer, it will be an easy matter to determine the efficiency of the magneto.

By installing this instrument when the car is first purchased the owner has a continuous check on the performance of the magneto and can remedy any deterioration that may take place before it has become sufficiently

acute to seriously interfere with the efficiency of the motor. As the strength of the current developed by the magneto is directly proportional to its speed it can hardly be expected to show the same efficiency at low speed that it does at normal or higher, but the average of a number of tests at various car speeds gave the following results: Up to 8 miles per hour—Poor; 10 to 15 miles per hour—Medium; 18 to 25 miles per hour—Good. Above 30 miles per hour—Excellent; and it can be taken as a safe rule that a magneto showing "Good" at any normal speed above 15 miles per hour is in reasonably good condition.

Model T Ford Truck.—The one-ton truck built by the Ford Motor Co. is practically the same in most details as the touring car except that some of the parts are naturally made stronger and a new type of worm drive rear axle is used. This is clearly shown at Fig. 114, the view at A showing the worm and its supporting bearings. That at B shows the worm gear and differential, also one of the axle shafts that drive the wheels. The axle is a live axle type, just as the bevel gear drive axle of the model T touring car is. The worm is at the top of the worm gear and differential assembly and the worm shaft is supported by roller bearings which take all radial load while end thrust is taken by a special ball bearing mounted at the back end of the worm shaft. The differential gear assembly is supported by cup and cone type ball bearings; the wheel end of the axle drive shaft revolves on a flexible roller bearing just as in the touring car. The power plant and control is the same as used in the passenger car but the worm gearing provides a lower gear ratio on account of the greater weight to be moved. The spring at the rear end is much stronger and the frame is made of heavier section pressed steel.

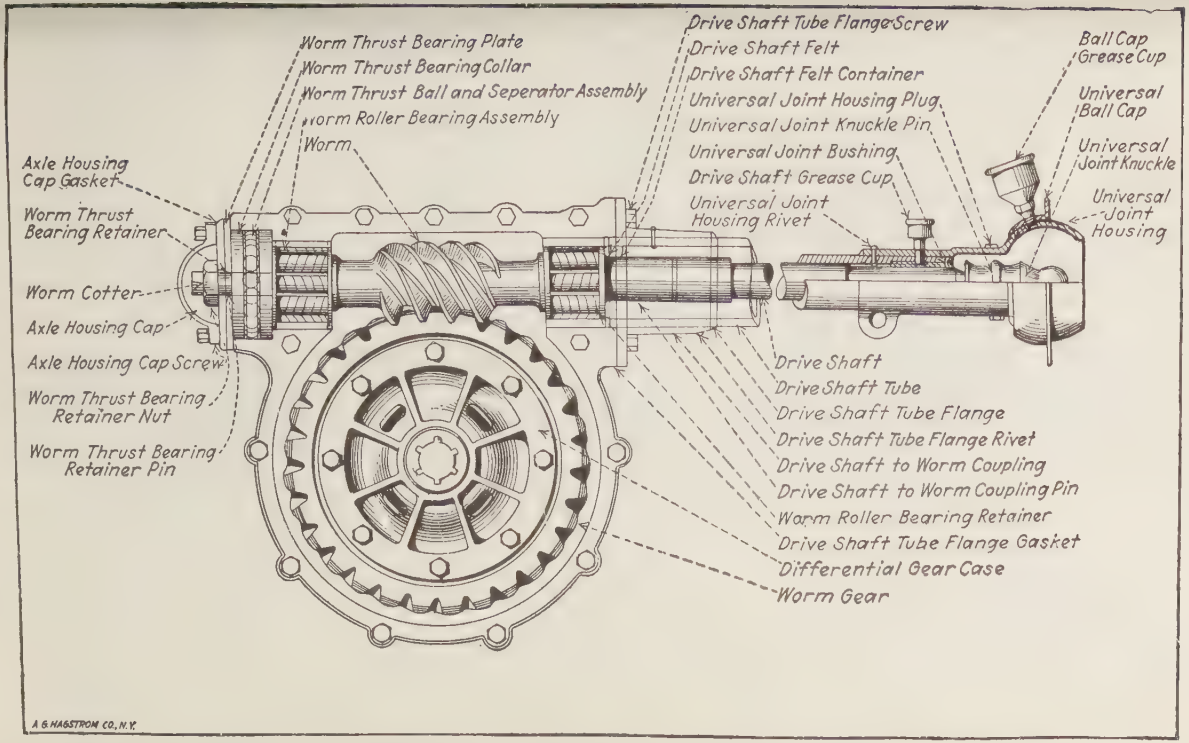


Fig. 114A.—Views of Worm Drive Gearing Used in Model T Ford Truck Rear Axle. Meshing of Worm and Worm Wheel is Shown.

The instructions previously given for the upkeep of the model T car apply to all parts of the truck except the rear axle. Full directions for the upkeep and repair of this important member of the truck follow.

To Remove Model T Truck Axle.—Jack up the truck, place supports under rear axle housings, and remove the rear wheels. Take out the four bolts connecting the universal ball cap to the transmission case and cover. Disconnect brake rods. Remove frame by placing a long iron bar or gas pipe under the frame just in front of rear spring, one end resting on the substantial support of the proper height. Two workmen at the other end of the bar can raise the frame and place the end of the bar on another support. The rear axle assembly can then be easily withdrawn.

Remove two plugs from top and bottom of ball casting and turn shaft until pin comes opposite hole, drive out pin and the joint can be pulled or forced away from the shaft and out of the housing.

With universal joint disconnected, remove the bolt in front end of radius rods and the cap screws which hold the drive shaft tube to the rear axle housing. Then remove the rear axle housing cap; also the bolts which hold the two halves of the differential housing together. With the differential exposed to view, the manner of disassembling it will be apparent. Care must be exercised to get every part back in its correct position when reassembling, being sure to use new paper liners.

How to Remove the Worm.—To remove the worm, drive out the pins which hold the coupling to the worm and drive shaft. Then remove the felt washer, roller-bearing sleeve and roller bearing by slipping them over the coupling. Drive the coupling off from the drive

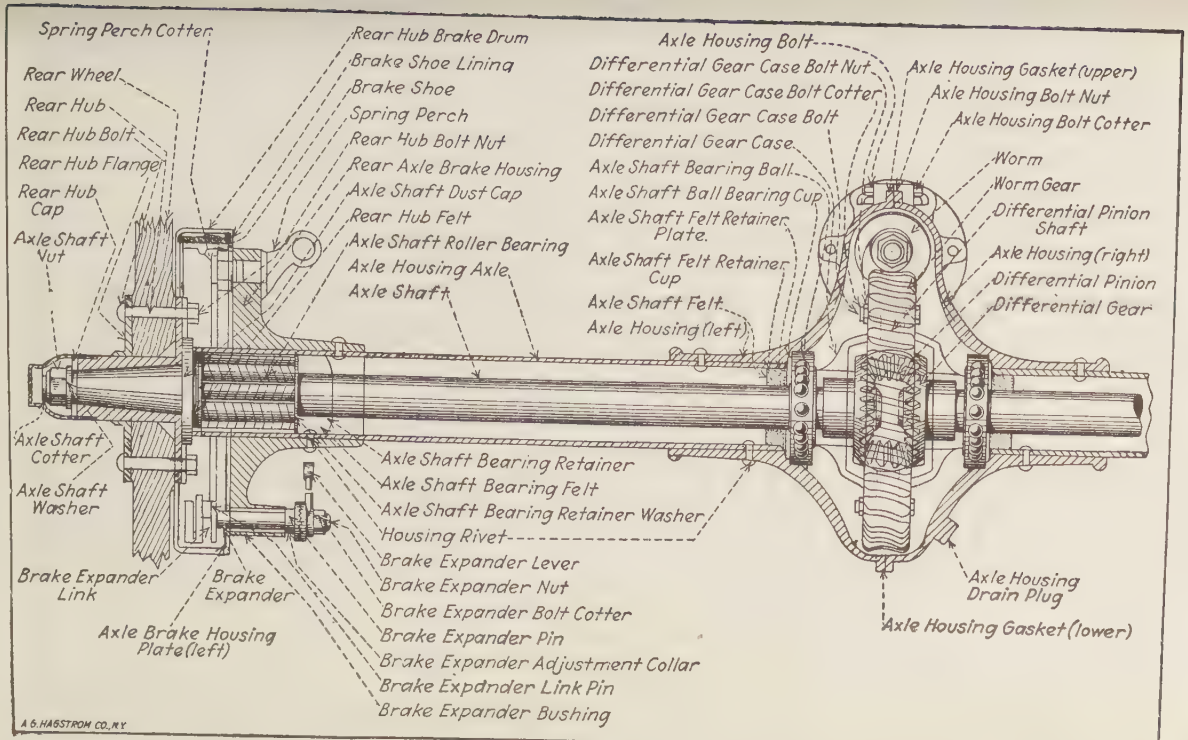


Fig. 114-B.—The Axle Shafts and Supporting Bearings of the Ford Model T Truck Axle.

shaft and then force the worm from the coupling. Removing the worm nut will permit the removal of the retaining washer, thrust bearing and rear worm-roller bearing. In reassembling be sure that the pin which holds the retaining washer stationary is in place.

Removing Rear Axle Shaft.—Remove the rear axle assembly as previously directed. Disconnect brake rods and radius rods at rear axle housing flange, also remove nuts holding spring perches to flanges. Take out the cap screws holding the drive shaft tube to the rear axle housing and remove the rear axle housing cap and the bolts which hold the two halves of the differential housing together; then pull or force the housings from the shafts and disassemble differential. After replacing the axle shaft be sure that the rear wheels are firmly wedged on at the outer end of the axle shaft and the key in proper position. When the truck has been driven thirty days or so make it a point to remove the hub cap and set up the lock nut to overcome any play that might have developed. It is extremely important that the rear wheels are kept tight, otherwise the constant rocking back and forth against the key-way may in time cause serious trouble.

Dismantling Differential Gear.—The differential gear is fastened to the inner end of the rear axle shaft by means of splines, and is held in position by a ring which is in two halves and fits in a groove in the rear axle shaft. To remove the gear force it down on the shaft, that is, away from the end to which it is fastened, drive out the two halves of the ring in groove in shaft with screw-driver or chisel, and force the gear off the end of the shaft.

Lubrication of Rear Axle.—Extreme care must be used

in lubricating the differential. An A-1 heavy fluid or semi-fluid oil, such as Mobiloil C or Whittemore's Worm Gear Protective, should be used and carried at a level with the upper oil plug. The differential is supplied with the required amount of lubricant when the truck leaves the factory and the supply should be maintained by replenishments as required.

After running the truck about 500 miles the oil should be drained off by removing the lower oil plug, and the differential filled with fresh lubricant. This operation should be repeated at approximately 1000 miles and after that whenever necessary. The rear axle outer roller bearings are lubricated by means of dope cups. These cups should be kept filled with a good grade of grease and given a full turn every 100 miles. Before putting the truck back in service after the rear axle has been taken down fill the differential with oil, jack up the axle and run it for five or ten minutes to insure proper lubrication of all bearings.

New Ford Repair Schedule.—The Ford Motor Co. recently issued a new schedule covering the cost of repair work at its branches and agencies. Distributors and dealers are not required to adhere strictly to this price list, but it is compiled to aid them in setting a reasonable charge on their work. In cases, we believe that the prices, as set by the company, are too low. As an example, compared with last year's price for overhauling a motor, the price has been reduced from $12 to $11. Following are the new prices set:

For Ford Repair.

Overhaul motor and transmission	$15.75
Overhaul motor only	11.00
Overhaul transmission only	4.00

Rebore cylinder only	1.50
Rebore cylinder only including fitting of pistons	2.55
Rebore and rebabbitt cylinder including fitting of pistons	3.75
Rebabbitt cylinder only	1.50
Rebabbitt cylinder, fit crankshaft and run-in	2.25
Rebore and rebabbitt cylinder including fitting of pistons, crankshaft, connecting rod and running in	5.00
Rebore and rebabbitt cylinder, fit-pistons, valves, push rods, camshaft, crankshaft, connecting rods and run-in	7.50
Rebore and fit pistons and valves	2.75
Rebore and fit pistons, valves and push rods, and straighten and fit camshaft	3.50
Fit pistons, crankshaft and run-in (rebored block)	1.25
Rebush three transmission drums	1.50
Rebush transmission drums—each	.60
Rebush and re-rivet three triple gear assemblies	1.25
Braze crankcase, arms and support	3.00
Repair crankcase, drain plug housing	2.00
Overhaul or repair carburetor	1.00
Disassemble 5/8 in., 9/16 in. or 3/4 in. magnets for flywheel and instal new set	.60
Straighten crankshaft	1.00
Straighten camshaft	.60
Straighten camshaft and fit bearings	1.00
If brazing crank case, arms and support and repairing crank case and drain plug housing are combined	3.00

CHAPTER VII

OPERATION AND MAINTENANCE OF FORDSON TRACTOR

Putting Tractor in Service—Precautions before Starting the Tractor—Transmission Oiling Important—Fill Both Fuel Tanks—Control Lever Arrangement—How to Start Fordson Tractor Motor—How to Shift Gears—To Put Tractor in Action—To Stop Tractor—How to Drive the Tractor—How the Clutch Works—How Vaporizer Works—Best Mixture of Air and Gas—Function of Shunt Valve Lever—Function of Float Mechanism—How Vaporizer is Adjusted—Gasoline May Be Used—Water in Fuel Causes Trouble—Construction and Action of Air Washer—Fordson Tractor Maintenance—Transmission Lubrication—Keep Timer Oiled—Keep Tractor Clean—Lubrication Chart—Putting Tractor Up for Winter—Important Instructions to Operator Summarized—Don't Race the Motor—Shifting Gears—Braking the Tractor—Lubrication—Hitch.

THE Fordson tractor has been in the market now for several years and thousands have been given tests that demonstrate their practical value in the numerous applications in agricultural work to which they have been applied. The general construction of this tractor, which is made by Henry Ford and Son of Dearborn, Mich., has been described in the preceding chapter, but owing to demands of our readers, information regarding the operation and use of this tractor as furnished by its makers has been compiled in a separate chapter because the importance of the subject warrants a more complete exposition in this 1926 edition.

Many farmers are already familiar with the opera-

tion of the Ford tractor motor which is modified slightly from that used in the passenger car for tractor use and increased in power. The ignition system is the same as used in the Model T, as is the cooling and engine lubrication. The gearing operates on the sliding gear principle, however, and the carburetor uses kerosene as fuel for regular operation though gasoline is used for starting purposes and for running the engine until it gets warmed up enough to use the heavier fuel.

The instructions that have been given in preceding chapters relative to repairs of the model T power plant apply just as well to that of the Ford tractor. The engine is subject to the same troubles as that of the passenger car and truck and the same remedies will cure them. Special instructions are given for handling the clutch and gear shift of the tractor, which differ in operation from similar devices in the touring car or truck. Suggestions are also given for the use of the tractor in plowing and interesting photographs are presented showing the tractor at work.

Putting Tractor in Service.—Before starting the tractor, the following instructions must be followed: (1) Fill the radiator with clean water. (2) Fill the crank case to the proper level with heavy, high-grade motor oil. (3) Fill the transmission housing to the level with heavy fluid gear oil. (4) Fill the kerosene tank nearly full. (5) Fill the gasoline tank nearly full. (6) Fill the air washer with clean water.

Precautions Before Starting the Motor.—Before starting the motor fill the radiator, by removing cover at top (see Fig. 117), with clean fresh water. If clean water cannot be obtained it is advisable to strain it through muslin or other similar material to prevent any foreign

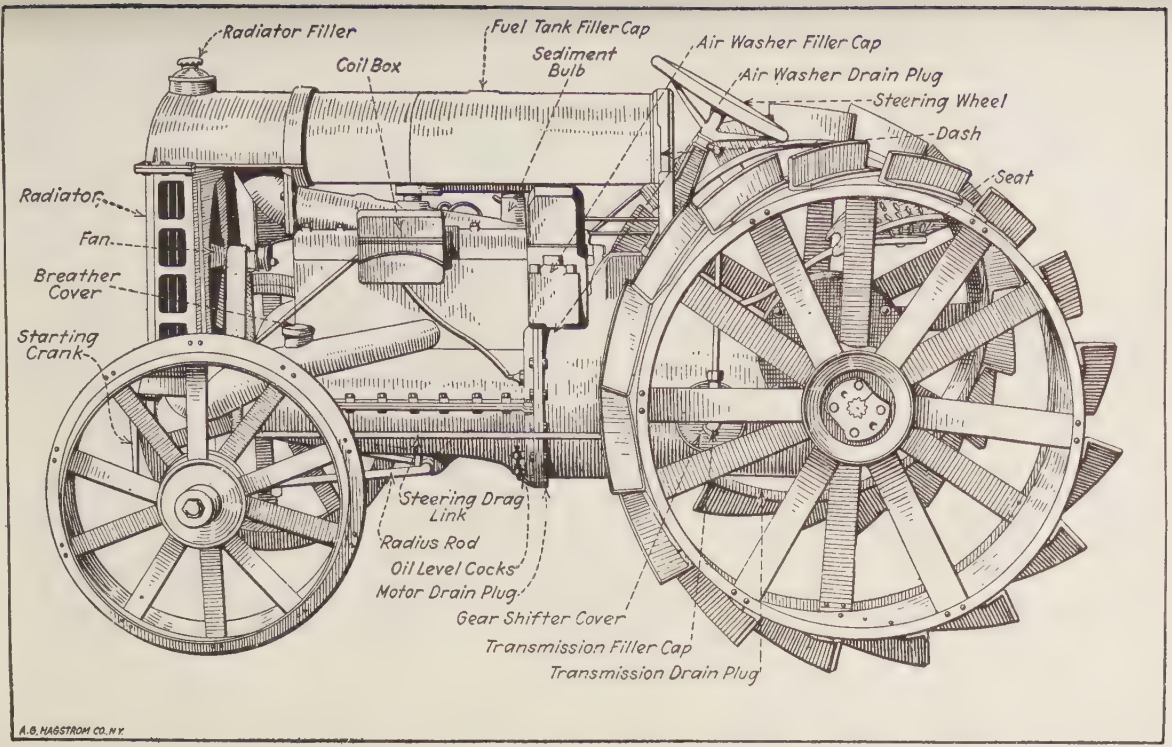


Fig. 115.—Ignition Coil Side of Fordson Tractor Showing Air Washer Location.

substance from getting in and obstructing the small tubes of the radiator. The system will hold approximately 11 gallons. It is important that the tractor should not be run under its own power unless the water circulating system has been filled.

Pour in the water until you are sure that both radiator and cylinder water jackets are full. The water will run out of the overflow pipe to the ground when the entire system has been supplied with an adequate amount.

During the first few days that a new tractor is being driven it is a good plan to examine the radiator frequently and see that it is kept filled. Soft rain water, when it is to be had in the clean state, is superior to hard water, which may contain alkalies and other salts which tend to deposit sediment and clog the radiator.

Upon receipt of the tractor see that a supply of heavy, high-grade motor oil is poured into the crank case through the breather pipe at the left-hand side of the motor as shown at Fig. 115. (A metal cap covers it.) At the side of the crank case you will find two small pet cocks, also shown at Fig. 115. Pour oil in slowly until it runs out of the upper cock. Place a clean measure under the pet cock to catch the oil so it will not run on the ground and be wasted.

Leave the cock open until the oil stops running, then close it. This will take about 2½ gallons of oil. When the tractor is being worked continuously, oil should be added to the motor twice a day. Under no circumstances should it be allowed to get below the lower cock. Always test oil level when the motor is not running and preferably when it is warm with the tractor on level ground.

Transmission Oiling Important.—Before starting the

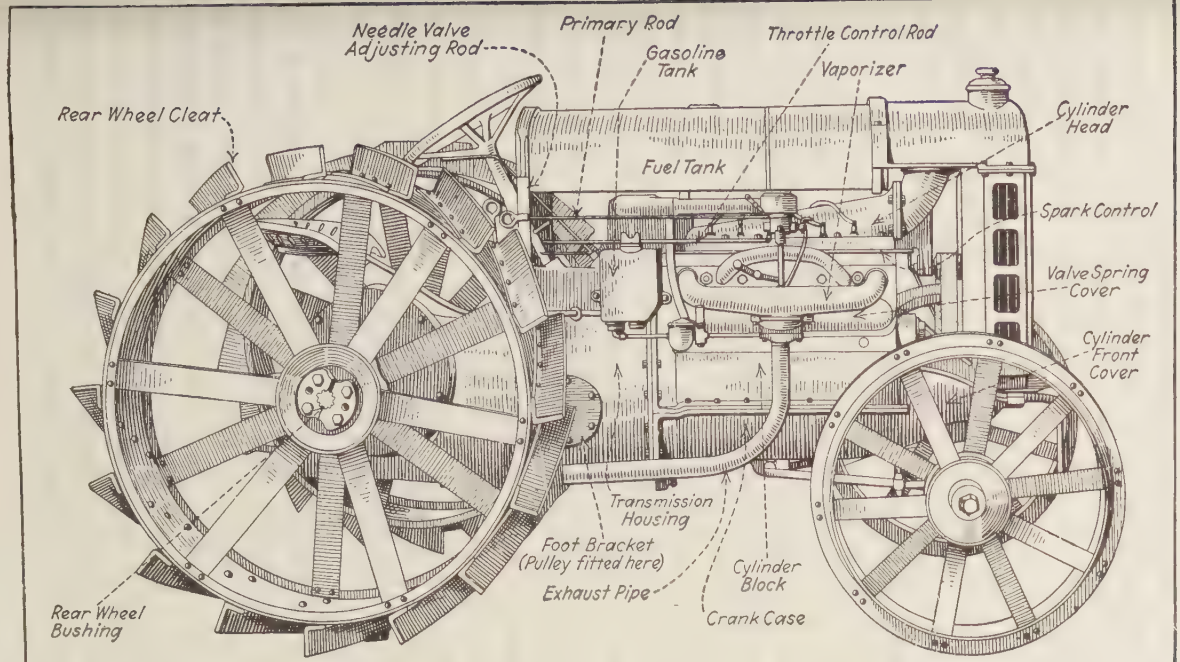


Fig. 116.—Valve Side of the Fordson Tractor Showing Auxiliary Tank for Gasoline and Location of Kerosene Vaporizer.

tractor see that a supply of heavy fluid gear oil is poured into the transmission housing through the filler hole in the gear shifter cover. Pour the oil in slowly until it reaches the level of the hole; as this oil runs slowly, it is advisable to warm oil to 100° F. Plenty of time must be allowed for the oil to reach all parts of the transmission and rear axle. Do not replace the filler cap until you are sure the housing has been properly filled. (This system holds about three gallons of oil.)

Fill Both Fuel Tanks.—As the tractor uses both gasoline and kerosene both tanks should be filled nearly full. The one-gallon gasoline tank is bolted to the air washer on the right-hand side of the tractor. Strain the fuel to prevent water and other foreign substances getting into the tank. Dirt or water in the fuel is sure to cause trouble. When filling the gasoline tank be sure that there are no naked flames within several feet as the gasoline vapor is extremely combustible and travels rapidly. Always be careful about lighting matches near where gasoline has been spilled.

The small vent hole in the filler cap should not be allowed to get plugged up, as this would prevent the proper flow of the fuel to the vaporizer. The tanks may be drained by removing the pipe plugs at the bottom.

Before starting the motor fill the air washer with clean fresh water by removing the filler cap at the side which is shown at Fig. 119. Pour in the water until it runs out of the filler hole and replace the cap. As the motor draws its air supply through the air washer a certain amount of water is carried off by the air in the form of moisture. It is necessary to make good this loss by frequently adding more water. If the level is allowed

to get too low, the air supply will be shut off, thereby causing the motor to stop. The air washer should be cleaned out every day by removing the drain plug at the side and flushing out with water.

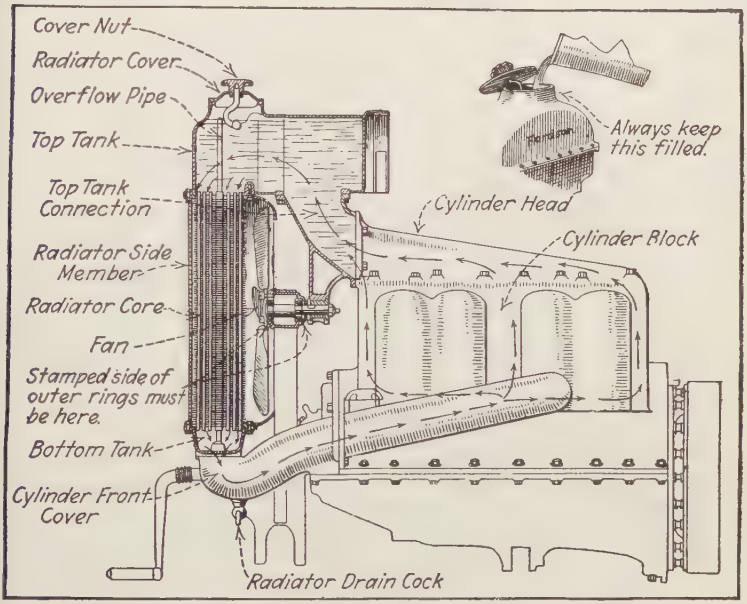


Fig. 117.—Sectional View of Fordson Engine Showing Water Cooling System. Inset Shows Method of Filling Radiator.

Control Lever Arrangement.—Under the steering wheel is located the throttle lever, which controls the amount of mixture (fuel and air) which goes into the motor. This is clearly shown at Fig. 120. When the motor is in operation the farther this lever is moved backward toward the driver (referred to as opening the throttle) the faster the motor runs and the greater the power furnished. The spark lever is mounted on the dash. This lever controls the spark which explodes the gas in the

cylinders of the motor. Moving the lever "upwards" advances the spark. It should be moved notch by notch until the motor seems to reach its maximum speed. If the lever is advanced beyond this point, a dull knock will be noticed in the motor.

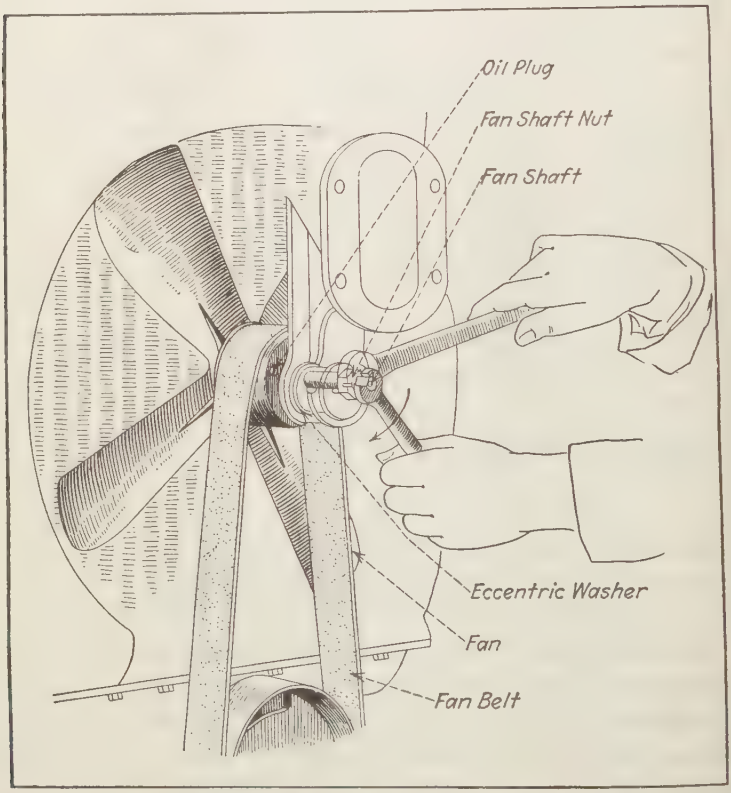


Fig. 118.—Diagram Showing Method of Tightening the Fan Belt on Fordson Tractor.

The spark lever should usually be moved upwards to the third or fourth notch. The throttle should usually be opened about one-third of the way. A little expe-

rience will soon teach you where the levers should be placed for proper starting. Care should be taken not to advance the spark lever too far, as the motor may backfire and injure the operator through the crank kicking back.

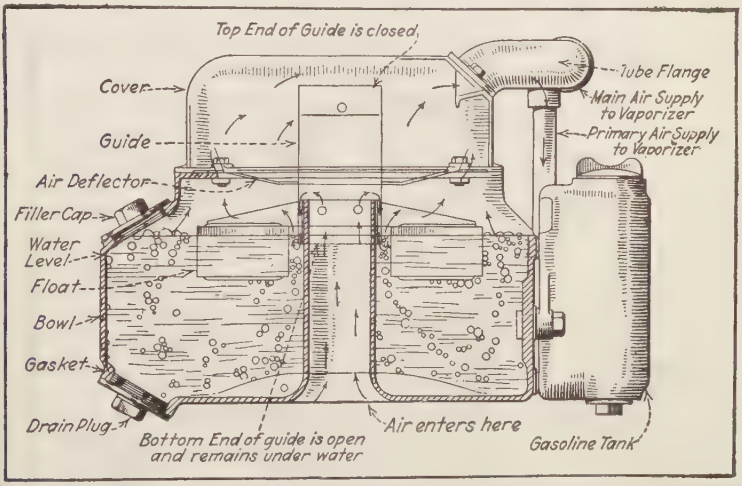


Fig. 119.—Diagram Showing Construction of the Fordson Air Washer Which Removes Dust and Dirt from the Air Before It Passes into the Carburetor.

The vaporizer is attached to the right side of the tractor, fastened on the side of which near the top is located the shifter valve. Turn this lever to the horizontal position, uncovering the letter G, allowing the motor to start on gasoline. This is shown at Fig. 121A in the kerosene position and covering the letter "G."

Near the center of the vaporizer is a shunt valve lever, as shown at Fig. 122, which controls the amount of heat supplied to the kerosene vapor tube. When starting the motor move this lever upwards to the "off" position so that the exhaust gases will not come directly

in contact with the vapor tube. After running the motor until the vaporizer is properly heated (usually one to five minutes, varying with the weather), move the shifter valve lever to the vertical position shown at Fig. 121A, uncovering the letter "K," turning the motor on to kerosene.

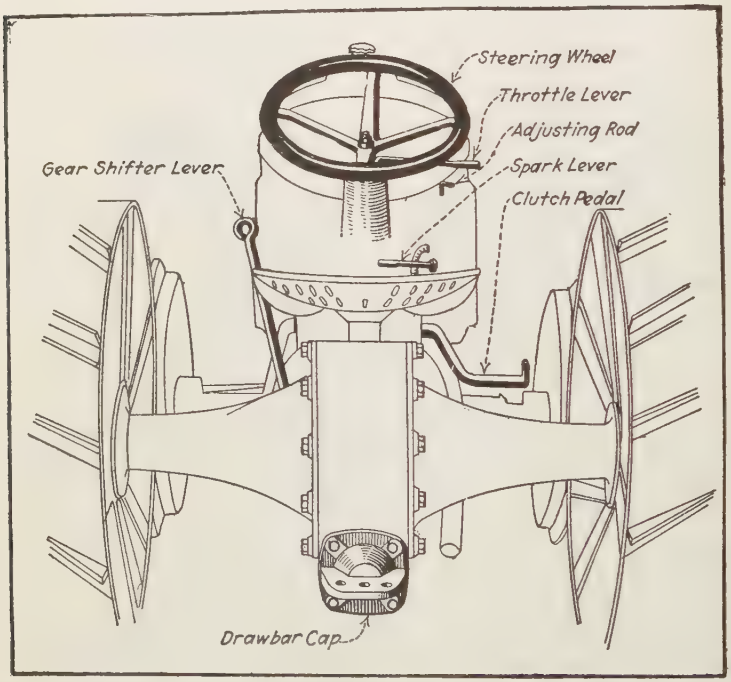


Fig. 120.—Rear View of Fordson Tractor Showing Control Members and Drawbar Cap.

How to Start Fordson Tractor Motor.—See that the gear shifter lever on the side of the transmissions is in the neutral (central) position, i.e., the position in which it can be moved freely from side to side. Turn on the

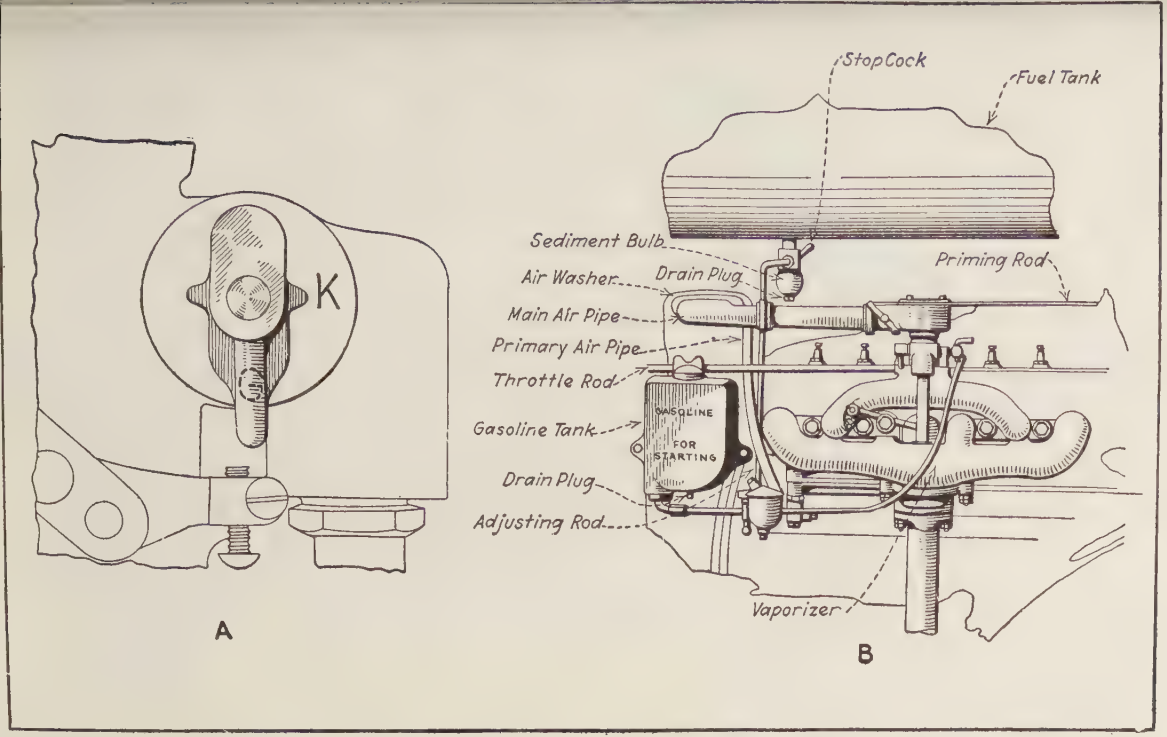


Fig. 121.—View at A Shows Fuel Control Valve That Supplies Either Gasoline or Kerosene to the Vaporizer. At B the Method of Installing the Vaporizer is Clearly Shown.

stop cock located on the right side of vaporizer. The next step is to crank the motor by lifting the starting crank at the front of the tractor.

Take hold of the handle and push the shaft in firmly towards the motor, rotating it slightly until you feel the pin engage the crank ratchet; then lift upwards with a quick swing. With a little experience this operation will soon become an easy matter. Don't, as a usual thing, crank downward against the compression—for then an early explosion may drive the handle vigorously backward. This does not mean, however, that it is not advisable when the tractor is hard to start to occasionally "spin" the motor by the use of the starting handle—but be sure the spark lever is retarded (down) when spinning or cranking the motor against compression—otherwise a sudden backfire may injure the arm of the operator. When cranking the motor the priming valve on top of the vaporizer should be almost closed. This is done by pulling out the priming rod on the right-hand side of the dash shown at Fig. 120. As soon as the motor commences to fire regularly the priming rod should be pushed back all the way. Do not keep the priming valve closed too long as the motor may get flooded with gasoline and refuse to fire.

As gasoline does not vaporize readily in cold weather it is naturally more difficult to start the motor under such conditions. The usual method of starting the motor when cold is as follows: (1) Close the priming valve by pulling the priming rod on the dash. Do not keep the priming valve closed too long as the charge that is drawn in is very rich in gas and will not explode readily in the cylinders. (2) Give the crank several quick

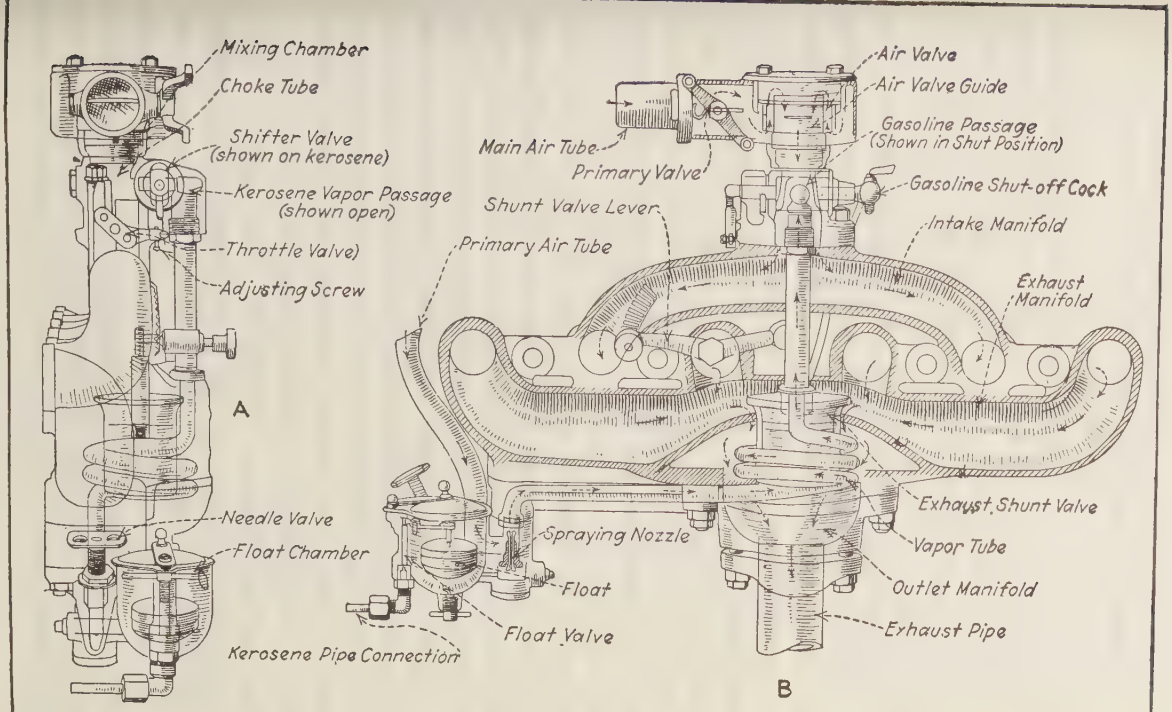


Fig. 122.—Sectional Views of Fordson Tractor Vaporizer Which Uses Kerosene as Fuel for Regular Running and Gasoline Only for Starting.

turns. (3) Open the priming valve slightly. (4) Give the crank one or two turns and the motor should start.

After starting it is advisable to advance the spark two-thirds of the way and let the motor run until it is heated up. If the tractor is started out with a cold motor it will not have much power and is liable to "stall."

The pedal on the right-hand side of the tractor (see Fig. 120) operates the clutch. It is used when starting and stopping the tractor and when changing gears. When pressed downwards it releases the clutch, thus disconnecting the motor from the driving gears. Always allow the clutch pedal to return slowly and smoothly. Sudden engagement of the clutch imposes excessive strain upon all parts and may "stall" the motor.

The lever to obtain various speeds is on the left-hand side of the tractor and engages the gears in the transmission and is shown at Fig. 120. The lever may be moved to five different positions as shown at Fig. 123. When in the neutral (central) position no gears are engaged; the lever must be in this position when motor is started. The four positions of the lever which are reached from the neutral position are: Low, Intermediate (plowing) High and Reverse.

How to Shift Gears. — Move the gear shifter lever from the neutral position into the desired positions as given below and shown at Fig. 123. To obtain Low: Move the lever outward to the left from the neutral position and push forward. Intermediate (plowing): Move the lever outward to the left from the neutral position and pull backward. High: Move the lever inward to

the right from the neutral position and push forward.

Reverse: Move the lever inward to the right from the neutral position, and pull backward. *Always release the clutch before engaging or disengaging gears.* Engage the gear in which it is desired to operate the tractor. It is not necessary to start in the low gear.

Practice changing gears and get accustomed to their various positions before attempting to start the motor.

To Put Tractor in Action.—After the motor has been started proceed as follows: (1) Push the clutch pedal downward with the foot, which releases the clutch. (2) Move the gear shifter lever into the desired position. (3) Then open the throttle slightly and as the speed of the motor increases allow the clutch pedal to return slowly by gradually raising the foot. As the clutch engages, it transmits the driving efforts of the motor through the transmission gears to the rear axle, setting the tractor in motion. If it should happen that the gears are in such a position that the ends of the teeth come against each other instead of sliding past, do not force them but return the gear shifter lever to the neutral position. Raise the foot, allowing the clutch to engage for an instant; then disengage the clutch by pushing the clutch pedal down and engage the gears as previously directed.

To Stop Tractor.—(1) Partially close the throttle. (2) Release the clutch by pushing the clutch pedal downward. (3) Move the gear shifter lever into neutral position—disengaging the gears. (4) Allow the clutch to re-engage by releasing the clutch pedal.

To stop the motor close the throttle and turn shifter to the horizontal position uncovering the letter "G" and pull priming rod out as far as it will go. This has the

effect of shutting off the air and filling the cylinders with a rich gasoline vapor which facilitates starting. *Never pull out priming rod while motor is running on kerosene.*

How to Drive the Tractor.—Good operators drive

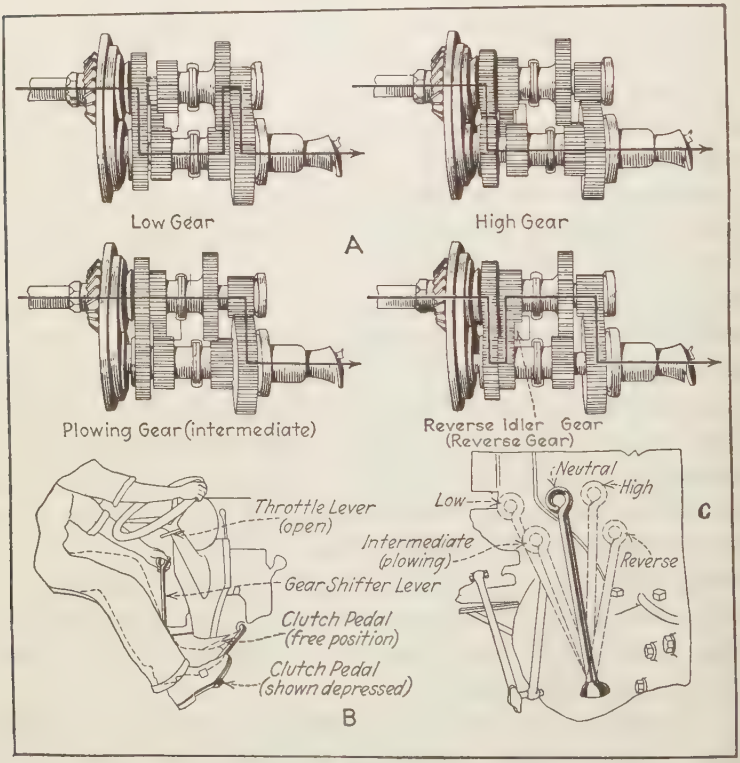


Fig. 123.—Diagram Showing the Various Combinations of Driving Gears to Obtain Different Speed Ratios and Course of Power Through Shaft and Gears at A. The Method of Operating the Clutch and Gear Shift Lever is Shown at B. Positions of the Gear Shift Lever to Obtain Various Speeds is Shown at C.

with the spark lever advanced just as far as the motor will permit. But if the spark is advanced too far a dull knock will be heard in the motor, due to the fact that

the explosion occurs before the piston in the cylinder has completed its stroke. The spark should only be retarded when the motor slows down under a heavy load or when idling. Care should be taken not to retard the spark too far, for when the spark is late, instead of getting a powerful explosion a slow burning of the gas with excessive heat will result. The greatest economy in fuel consumption is obtained by driving with the spark advanced sufficient to obtain the maximum power.

Always change the gears to suit load conditions. Always use the highest gear ratio on which the tractor will give the necessary pull. A little experience will soon teach the driver the proper gears to engage and the best speed at which to run the motor. Never try to do any heavy work in high gear. The speed of the motor is controlled by opening or closing the throttle to suit operating conditions and should be kept nearly constant at all working speeds of the tractor. When running at 1000 revolutions per minute the motor delivers its greatest driving effort and this is the speed at which it should be run when the tractor is working.

When the motor is running at 1000 revolutions per minute the four gear changes give the tractor the following speeds: Low: 1½ miles per hour. Intermediate (plowing): 2¾ miles per hour. High: 6¾ miles per hour. Reverse: 2½ miles per hour. Use the gear changes to obtain variations in the tractor speed. Never run the motor above the proper speed.

The speed can be judged by observing the number of complete turns made by the rear wheels in one minute. In low gear the rear wheels turn 12 times per minute. In intermediate gear the rear wheels turn 22 times per minute. In high gear the rear wheels turn 54 times per

minute. In reverse gear the rear wheels turn 21 times per minute.

The tractor is of simple construction and very accessible so most of the ordinary adjustments can be made by the driver, who will soon learn to make them himself. In making any extensive repairs or replacements it is best to employ the services of the skilled mechanic who thoroughly understands the tractor.

Remember that a new machine requires more careful attention during the first few days it is being driven than after the parts have been thoroughly "worked in." The tractor which is driven carefully when new usually

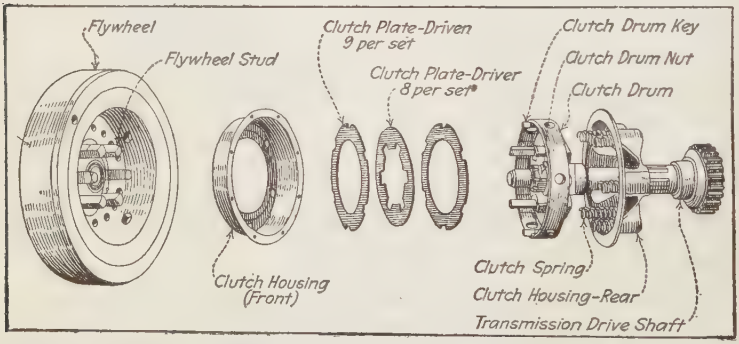


Fig. 124.—Parts Comprising the Fordson Tractor Clutch Assembly as They Appear When the Clutch is Dismantled.

gives the most satisfactory service in the end. See that the tractor has plenty of oil and water before starting work. If the tractor is left in the open over night, see that it is properly covered. The tractor cover is supplied for that purpose. Nothing will shorten the life of the tractor or in fact any farm machinery more than being left exposed to the weather.

Inspect the tractor daily and see that all bolts and

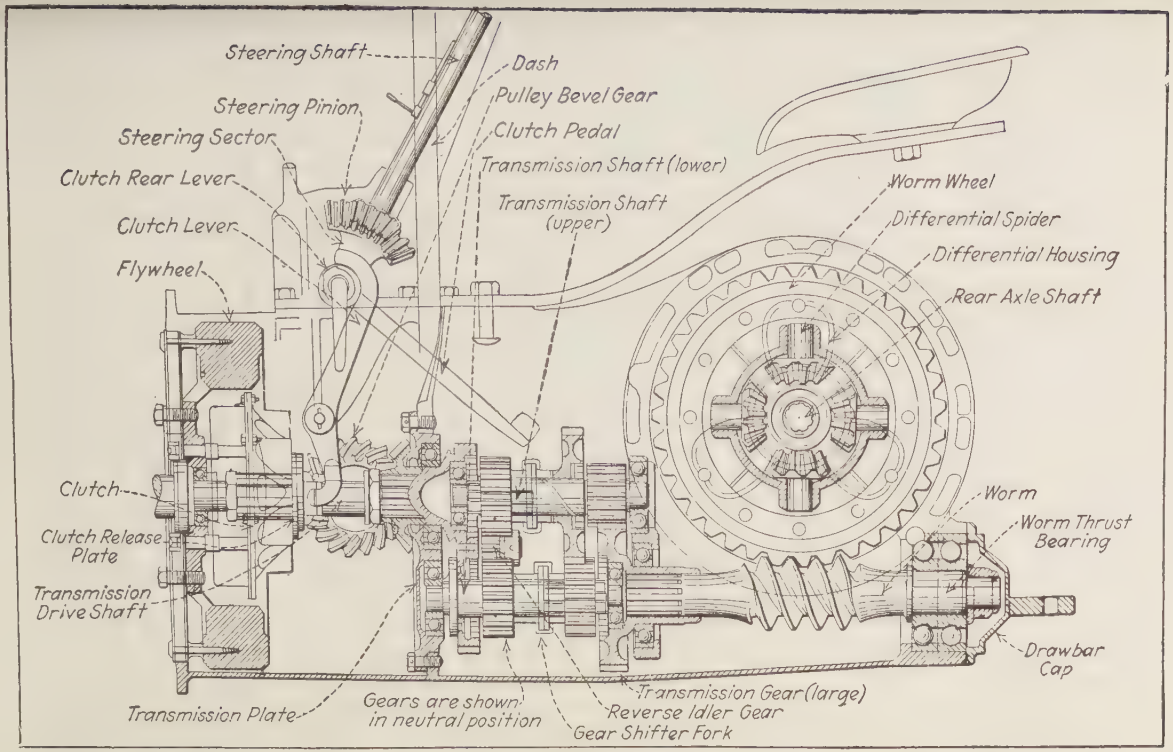


Fig. 125.—The Clutch, Change Speed Gearing and Worm Drive Gearing of the Fordson Tractor.

nuts are tight. Make a practice of taking care of every repair and adjustment as soon as its necessity is discovered. This attention requires but little time and may avoid delay or accident in the field. When the tractor is delivered it is in proper mechanical adjustment. Afterwards it is plainly the duty of the owner to keep it in that condition.

How the Clutch Works. — The power is transmitted by the frictional engagement between two sets of plates forced together by springs. The driving set of plates fit on six studs fixed in the flywheel; the set of driven plates fit six keys in the clutch drum, which is fixed on the drive shaft. When the clutch is engaged by allowing the clutch pedal to rise—the six springs force all the plates together, the resulting friction causing them to revolve as one solid unit. When the clutch is disengaged—by pressing down on the clutch pedal—the spring pressure on the plates is released, allowing them to slip past each other, thus permitting the motor to run free. The illustration at Fig. 124, shows the relative assembling positions of these parts.

The clutch is lubricated by the oil splashed up by the flywheel. No adjustment is necessary in the clutch. If it slips when working it will be due to weak springs or worn plates and they should be replaced by new ones. If the clutch sticks and does not release easily it should be taken apart and examined; bent clutch plates or burnt oil usually cause this trouble. If any of these be found they should be removed and replaced by new ones.

The clutch is released by the pedal on the right-hand side of the tractor. It acts on the clutch release plate causing the clutch housing to move in a forward direction. This releases the spring pressure from the clutch

plates. After engaging gears always let the pedal rise gently and when driving do not rest your foot on the pedal as it will cause unnecessary friction and wear the clutch release plate as well as causing the clutch to slip.

How Vaporizer Works.—The vaporizer is the device in which the fuel is mixed with the correct proportion of air to form a "charge," which is sucked into the cylinders and then exploded by an electric spark. The vaporizer is so constructed as to allow for varying the proportions of air and fuel to meet varying climates and operating conditions. As the tractor has two fuel systems, i.e., gasoline and kerosene, the vaporizer is also fitted with two devices to work with either. The view of the vaporizer at Fig. 132, shows its operation. When using gasoline for starting, the shifter valve is turned to the horizontal position, uncovering the letter "G." When in this position the gasoline enters the mixing chamber through a small passage drilled in the shifter valve. In the mixing chamber it is vaporized by the air drawn through the main air tube and past the shifter valve. No heat is used to vaporize the gasoline.

After the motor has been running at least one minute, the shifter valve is turned to the vertical position uncovering the letter "K," as shown at Fig. 121. The path of the kerosene mixture is shown on the illustration by solid black arrows; the broken line arrows indicate the path of the entering air, while the white arrows show the path of the exhaust gases after they leave the cylinder. The kerosene enters the float chamber through the float valve controlled by a metallic float.

From the float chamber the fuel passes through a hole regulated by a needle valve, to the spraying nozzle. When leaving this nozzle the fine spray is mixed with a

small amount of air entering through the primary tube and is drawn up the heated vapor tube, where it is completely vaporized and forms an extremely rich vapor. The heated vapor then passes through the shifter valve and enters the mixing chamber at the choke tube; there it is mixed with the balance of the air drawn through the main air tube.

The mixture is then in the proper proportion for perfect combustion and is sucked into the cylinders through the intake manifold. The volume of gas mixture entering the cylinders is regulated by the throttle valve just under the choke tube.

Best Mixture of Air and Gas.—A lean mixture has too much air and not enough fuel. A rich mixture has too much fuel and not enough air. A rich mixture will not only quickly cover the cylinder heads, pistons and valves with soot but will also tend to overheat the cylinders and is likewise wasteful of the fuel. It will often choke the motor and cause misfiring at low speeds.

The mixture should be kept as lean as possible without the sacrifice of any of the power of the motor. Too lean a mixture will result in backfiring through the vaporizer, for the reason that the gas burns slowly in the cylinder and is still burning when the inlet valve opens again, causing the gas in the intake manifold to ignite by the backfire. A rich mixture is shown by a heavy exhaust smoke. Proper mixture will cause very little smoke or odor.

The air valve is located at the top of the mixing chamber and automatically controls the quantity of air entering the vaporizer. It is so proportioned that while on its seat it admits the air necessary for idling and lifts gradually as the throttle valve is opened. It gives the

correct proportion of air to the mixture at any speed and load.

Function of Shunt Valve Lever.—This is used to regulate the amount of heat necessary to vaporize the kerosene in the vapor tube. When the valve lever is at the "on" position the exhaust from the cylinder passes around the vapor tube giving the maximum heating effect. When the lever is shifted to the "off" position the exhaust then passes through the center of the shunt valve and does not pass around the vapor tube. This gives a lower temperature at the mixture and should only be used when the tractor is doing heavy pulling in hot weather. If the motor is left running without load the lever must be shifted to the "on" position and the spark fully retarded—otherwise the motor will smoke and the spark plugs will get dirty.

Function of Float Mechanism.—This automatically controls the flow of kerosene into the vaporizer. The float should close the valve when the kerosene reaches the proper level, indicated by a groove inside the float chamber. The level must not be above this line or more than one-eighth of an inch below. The flow of kerosene entering the vaporizer through the fuel pipe is automatically regulated by the float valve raising and lowering on its seat. Should any particle of dirt become lodged in the seat, which prevents the valve from closing, the kerosene will overflow and leak out.

How Vaporizer Is Adjusted.—The vaporizer has but one adjustment—the kerosene needle valve as outlined in the side view at Fig. 122A. The usual method of regulating is to start the motor on gasoline and run it for two or three minutes—keeping the shunt valve on the "off" position. Turn down the needle valve lightly to

its seat, then open it two and one-half turns. Turn the shifter valve on to kerosene, also shifting shunt valve lever to the "on" position; retard the spark lever to about the fourth notch and open the throttle until the motor is running at a good speed. The flow of kerosene should then be cut off by screwing the needle valve down to the right until the motor begins to misfire; then gradually increase the kerosene supply by opening the needle valve until the motor reaches its highest speed and no smoke comes from the exhaust.

After the best adjustment has been found the driver should observe the angle of the adjusting rod on the dash. In cold weather it will probably be found necessary to turn the adjusting rod one-quarter turn to the left, particularly before the motor has been thoroughly warmed.

Gasoline Can Be Used.—If desired gasoline can be used with results quite as good as those obtained when using kerosene. It should, however, be put into the fuel tank and used in exactly the same manner as kerosene. Running the tractor for a period of more than five minutes from the small gasoline tank may burn out the vapor tube. When running the tractor on gasoline, always have the shunt valve on "off" position.

Water in Fuel Causes Trouble.—The presence of water in the gasoline or kerosene tank, even in small amounts, will prevent easy starting and may cause the motor to misfire and stop. As water is heavier than either gasoline or kerosene, it settles to the bottom of the tank and into the sediment bulb. It is advisable to frequently drain the sediment bulb under the kerosene tank and also the gasoline tank by removing the pipe plug in the bottom.

During cold weather the water which accumulates in the sediment bulb may freeze, preventing the flow of kerosene to the vaporizer. Should this happen wrap a cloth around the sediment bulb and keep it saturated with hot water for a short time. The water should then be drained off. In the event of water getting down into the carburetor and freezing the same treatment may be applied.

The gasoline passage in the shifter valve being very small a minute particle of grit or other foreign matter will clog up the hole and prevent the motor from starting. Should this occur, remove the shifter valve and clean out the small hole.

Should dirt get into the kerosene it may clog the spraying nozzle causing the motor to misfire and slow down. The nozzle can be taken out and cleaned by removing the plug which screws into the float chamber just under the nozzle.

If the motor runs too fast with throttle fully retarded unscrew the throttle lever, adjusting screw until the motor idles at suitable speed.

Construction and Action of Air Washer.—It serves two purposes. First: To remove all dust and solid matter from the air before it enters the cylinders of the motor, preventing excessive wear to the pistons and cylinder walls. Second: It moistens the air in its passage through the water and helps to avoid pre-ignition of the gas mixture in the cylinders. The suction of the pistons in the cylinders draws the air into the air washer through the central passage. It is then guided downward and into the water. In its passage through the water it gets rid of all dust and becomes moist. The air is then drawn off through the tube flange on top to the

vaporizer. The interior construction is clearly shown at Fig. 119.

In order to get proper operation of the air washer, it is necessary that the air should enter the water at a certain distance below the water level. To compensate for the variation in the water level a float is used. The float then keeps the open end of the air guide at the proper distance under water.

The dust collected from the air causes the water to become muddy and in a short time would prevent its proper operation. The water and mud should be removed every day by unscrewing the drain plug at the side and the air washer flushed out. Replace the plug and fill up to the level of the filler hole with clean water.

If the water level is allowed to become low the guide fixed to the float cuts off the air supply, causing the motor to miss fire and stop.

Fordson Tractor Maintenance.—The most important feature in the maintenance of the tractor is proper lubrication. The plan view at Fig. 126 shows the points of lubrication and the chart specifies the attention required. This chart should be studied carefully and often. Only high-grade oils should be used and the instructions regarding time and kind of oil should be carefully followed. Frequent inspection and lubrication is essential to insure the proper running and long life of the tractor.

The oiling of the motor must be given close attention. Use only a heavy, high-grade motor oil. It should have sufficient "body" so that the pressure between the bearing surfaces will not force the oil out and allow the metal surfaces to come in contact and seal piston ring clearance. Inferior oils have a tendency to

carbonize quickly, also to gum up the piston rings, valve stems and bushings.

The motor is oiled by the splash system from the oil reservoir in the crank case. Oil should be added at

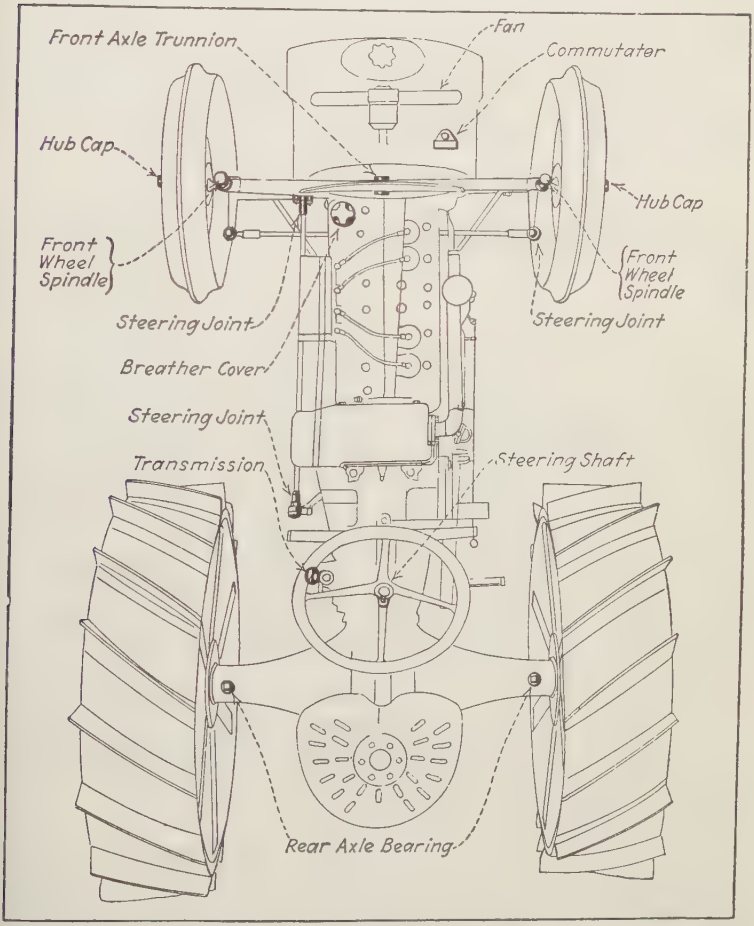


Fig. 126.—Plan View of the Fordson Tractor Showing Points That Demand Periodical Lubrication.

least twice per day and under no circumstances should the level be allowed to drop below the lower pet cock. It is best to test the oil level and fill the motor when it is warm. This will avoid the possibility of adding too much oil as when cold the oil is sluggish and may not run freely out of the pet cock. If too much oil is put in the motor it will form carbon in the cylinders and also dirty the spark plugs. To insure crank case from

Lubrication Chart

PART	HOW OFTEN	WHAT TO USE	WHAT QUANTITY
Motor	Twice a day	Heavy motor oil	Up to top pet cock
Transmission	Once a day	Heavy fluid gear oil	Up to level of filler opening
Commutator	Twice a day	Motor oil	A few drops
Two Front Spindles	Once a day	Cup grease	A few turns
Front Axle Trunnion	Once a day	Motor oil	Oil thoroughly
Radius Rod Pin	Once a day	Motor oil	Oil thoroughly
Fan	Once a week	Heavy fluid gear oil	Oil thoroughly
Two Rear Axle Bearings	Once a week	Heavy fluid gear oil	Oil thoroughly
Steering Shaft	Once a week	Cup grease	A few turns
Front Wheel Hubs	Every other week	Cup grease	Fill up
Four Steering Joints	Once a day	Motor oil	Oil thoroughly

As the life and efficient working of the tractor depend on proper lubrication, it cannot be too often brought to the attention of drivers and mechanics that neglect in this direction may be the cause of endless and serious trouble.

dirt accumulations care should be taken to keep space about breather cap clean, and make sure it is clean when oil is poured in.

When a new tractor has been driven a few days the

oil in the crank case must be drained off and the motor refilled with entirely fresh oil. It will be necessary to repeat this operation every week if the tractor is being used continuously. Remove the drain plug underneath the crank case and drain off the oil, flush out with a quart or so of kerosene to remove sediment and dirty oil, replace the plug and refill with fresh oil to the level of the top pet cock.

The oil which is drained off the motor can be used to lubricate machinery around the farm so that no oil is wasted. Whenever the motor is disassembled for repairs the opportunity should be taken to thoroughly clean out the oil pipe, which is located in the upper half of the crank chamber.

The clutch and steering gear are lubricated by the oil in the crank case, which is thrown up by the flywheel. They receive a plentiful supply of oil and require no attention if the oil in the crank case is kept at the proper level.

Transmission Lubrication.—The transmission and rear axle are lubricated by a single oil bath in the transmission housing. Use only a heavy fluid gear oil. It should, however, be able to flow readily at body temperature. On no account should a light motor oil be used in the rear axle.

The oil level should be inspected twice a day. Add oil when the motor is warm; it is advisable to warm oil to 100° F. Be sure it has reached every part before replacing the filler cap. The oil should be poured in until it reaches the level of the filler cap hole. It is necessary to drain off the oil every two weeks if the tractor is in constant use and replace with fresh oil. Remove the drain plug underneath the housing, and after all oil has

been drawn off, flush it out with a quart or so of kerosene. Replace the plug and refill with fresh oil. This operation should be done when the tractor is warm as the oil will then flow more readily.

Should the oil be left unchanged too long, or if a light oil is used, the transmission housing will become very warm when the tractor is in use. This condition must be remedied immediately or excessive wear will be caused to the moving parts.

Keep Timer Oiled.—Keeping the commutator well oiled is a matter of far greater importance than many drivers believe and is necessary in order to have a smooth operating motor. Do not be afraid to put a little light oil into the commutator twice a day. Remember that the commutator brush revolves very rapidly, and without sufficient lubrication the parts soon become badly worn. When in this condition perfect contact between the brush and the four contact points is impossible and as a result the motor is apt to misfire when running at a good rate of speed.

Keep Tractor Clean.—The tractor should be kept free from rust or dust. If allowed to accumulate it may in time get carried into the bearing surfaces and cause unnecessary wear. Wash the tractor frequently and keep it well painted to prevent rusting. When washing care must be taken that no water reaches the wiring coil box or spark plugs as this would result in short-circuit and failure of the ignition system.

The most important point in maintenance of a tractor is proper and efficient lubrication and cleaning. Frequently inspect the tractor. See that it is kept properly adjusted and that all bolts and screws are tight.

The ball bearings used in the tractor will last in-

definitely if they are kept well lubricated and free from grit. When the tractor is being overhauled or repaired the ball races should be cleaned with kerosene and examined carefully. If any chipping of the balls or pitting of the races is found, the bearing should be replaced by a new one. It is impossible to replace a broken ball. Be careful that all bearings are replaced with the stamped face of the outer ring in the correct position, or seated against the shoulder in the housing.

Putting Tractor Up for Winter.—Drain the water from the radiator and then put in about a quart of denatured alcohol to prevent freezing of any water that may possibly remain. Drain the water from the air washer. Drain off the kerosene and gasoline. Drain off dirty oil from the crank case and refill with fresh oil; crank the motor enough so that the different parts get covered with oil. Cover the tractor with the tractor cover and store in a dry place.

Important Instructions to Operators Summarized.—If the motor develops a knock it is important the cause be investigated at once and corrected. If not corrected, it becomes more pronounced, thereby causing lack of power and tending to shorten the life of the motor.

Never attempt to continue work with the tractor when the motor fires only in two or three cylinders. Besides losing power and wasting fuel, it causes raw kerosene to get into the crank case, thinning the lubricating oil.

Don't Race the Motor.—The worst abuse that can be given the tractor is by racing the motor. Drivers must avoid this at all times. The proper speed to run the motor is 1000 revolutions per minute. This will give the tractor the correct working speeds as previously given. When the motor is idling cut the speed down as

low as possible and retard spark (spark lever down). When starting do not speed the motor to heat up the vaporizer quickly. This is destructive to the tractor and will not accomplish your purpose.

Shifting Gears.—Do not attempt to engage or disengage gears until clutch pedal has been pushed down all the way, nor while the tractor is in motion. When changing gears, if the clutch is not entirely disengaged the teeth on the gears will not mesh readily and there is danger of breaking off the edges of the teeth so that in time they will not remain in mesh. Always close the throttle to slow down motor when shifting gears.

Braking the Tractor.—Do not run the tractor downhill with the gears in neutral or with the clutch released. Engage the gears either in low or intermediate speed and use the throttle to govern the speed of the motor. In low gear, for every revolution made by the rear wheels, the motor must turn eighty-five times, which acts as an effective brake.

Lubrication.—The importance of correct lubrication cannot be too strongly impressed on tractor drivers. The proper grades of oil must be used in the motor and transmission—motor oil must never be used in the transmission. The proper oil level must be maintained at all times. Do not forget that lubricating oil wears out and gets dirty and should be replaced frequently.

Clean oil will protect the motor bearings and cut down spark plug trouble.

Hitch.—The drawbar cap (see Fig. 120) is provided for your convenience in hitching. Always hitch to this drawbar cap. Do not hitch a chain or rope around the rear axle housing under any circumstances.

When pulling a heavy load—or in case the tractor be-

comes mired—be sure to keep your foot on the clutch pedal. Do not race the motor or let the clutch in suddenly, as this might lift the front end of the tractor off the ground. Should this happen, release the clutch immediately—this will bring the front wheels back to the ground at once.

If the tractor should become mired, always pull out in low gear. Do not attempt to pull tree stumps or to do any similar work that might bring the tractor to a sudden stop.

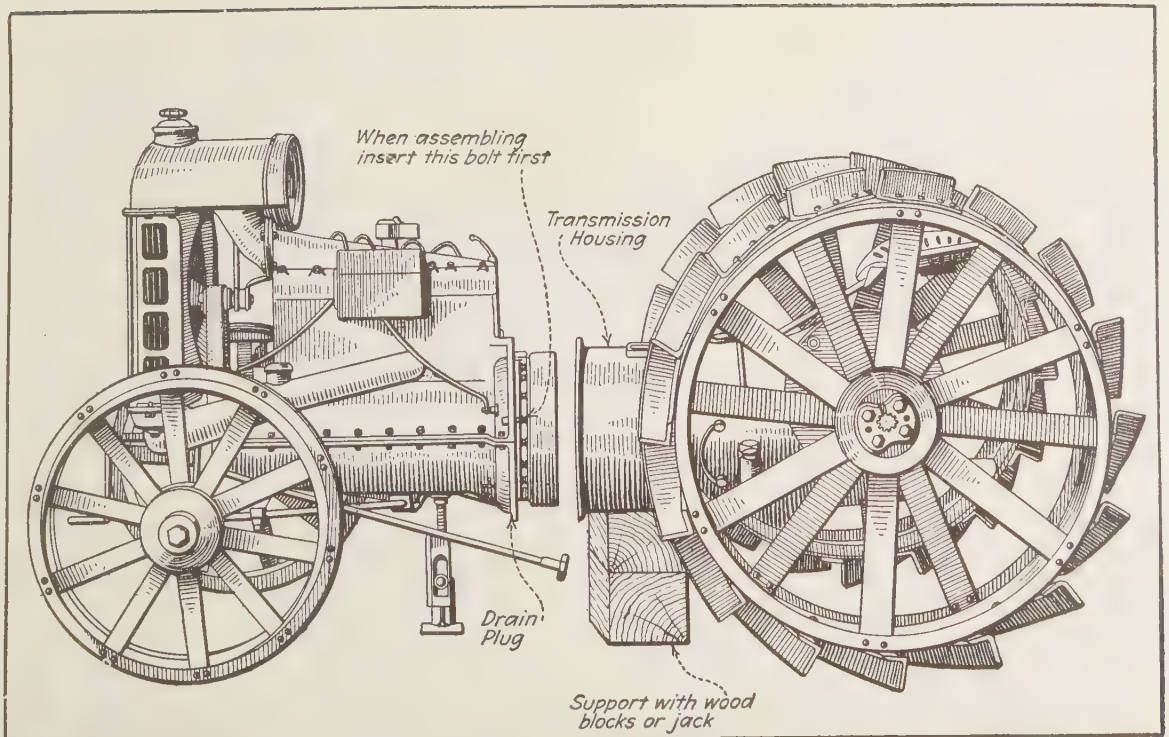


Fig. 127.—How to Take the Fordson Tractor Apart in the Middle to Gain Access to the Change Speed Gearing or Clutch.

CHAPTER VIII

REPAIRING AND USING FORDSON TRACTOR

How to Dismantle Tractor—Removing Clutch—Tractor Running Gear Parts—Removing Front Axle—Adjusting Front Wheel—Fitting Drag Link Ball End—Dismantling Rear Axle—Removing Differential Gear from Shaft—Removing Wheel—Roller Bearings Need Oil—How to Remove Transmission—Summary of Motor Troubles and Their Causes—Motor Fails to Start—Motor Lacks Power or Runs Irregularly—Motor Stops Suddenly—Motor Overheats—Motor Knocks—Timing Fordson Tractor Motor—Fordson Tractor Plowing—Adjusting Penetration of Plow—Fordson Tractor Has Many Uses—Combination Hitches—Power Needed for Hauling—Energy Absorbed by Plows—Fordson Horsepower—Fordson Power Take-Off—Installing and Using Belt Pulley Attachment—Extension Rims—Tools and Equipment for Care of Tractor—Combined Tractor House and Farm Workshop.

How to Dismantle Tractor.—When it is necessary to disassemble the motor or transmission for repairs or adjustment proceed as follows: (1) Drain the oil from the motor. (2) Empty radiator and water jackets by opening the small cock under the radiator. (3) Close stop cocks on sediment bulb and gasoline tank and remove fuel tank. (4) Remove the air washer and gasoline tank. (5) Disconnect the steering arm from the drag link and the control rods from the commutator and vaporizer. (6) Remove the dash by unscrewing the four cap screws holding it to the transmission housing. (7) Jack up the transmission housing as well as the

motor separately, being careful to place a wedge on both sides between the cylinder front cover and the front axle so as to prevent the motor from tilting over when it is disconnected. (8) Remove the bolts from the cylinder flange holding the motor to the transmission housing; the rear part of the tractor can then be drawn away from the motor (see Fig. 127).

When assembling the tractor it is important that the two bolts, one on each side of the cylinder flange just above the crank case, be inserted first. The holes in which these two bolts fit are smaller and being reamed accurately they bring the motor and transmission into correct alignment.

Removing Clutch.—Remove the motor from the rear part of the tractor. Remove the nut on the end of the drive shaft which holds the clutch in place and pull the clutch off. The clutch can then be taken apart by removing the eight bolts holding the front and rear housings together. In assembling, oil the plates well and be sure they are replaced in their proper order; that is, the driving and the driven plates must alternate and the two end plates must be driven plates. (Have the slots on the outside edge.) When replacing the clutch on the drive shaft, be sure the split ring is in place and that the clutch drum fits over it properly.

After the tractor has been in use for some time the wear on the clutch release plate may cause the clutch pedal to strike the foot rest, before the clutch is fully disengaged. When this happens it can be adjusted in the following manner:

(1) Remove the air washer.
(2) Remove the dash.
(3) Take out the pin holding the steering gear sec-

tor on the steering arm (inside the dash) and remove the steering arm.

(4) The cam which fits on the end of the clutch pedal can now be removed.

(5) Advance the cam one or two notches to the right and replace, being sure that the split ring, which it holds, is in place.

(6) Try out the new position of the clutch pedal and if it is satisfactory replace the dash.

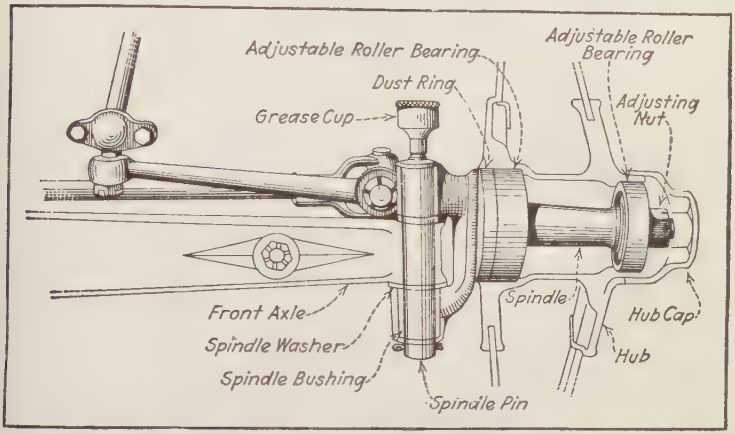


Fig. 128.—View of Fordson Tractor Front Wheel Showing Bearing Mounting.

Tractor Running Gear Parts.—These should be carefully gone over every week to see that all bolts and connections are secure, and any looseness in the steering joints should be taken up. The working parts should be well lubricated at all times and kept free from dust and mud. Should the axle or spindle become bent, extreme care must be used to straighten the parts accurately. Do not heat the forgings, as this will distemper the steel, but straighten them cold. If con-

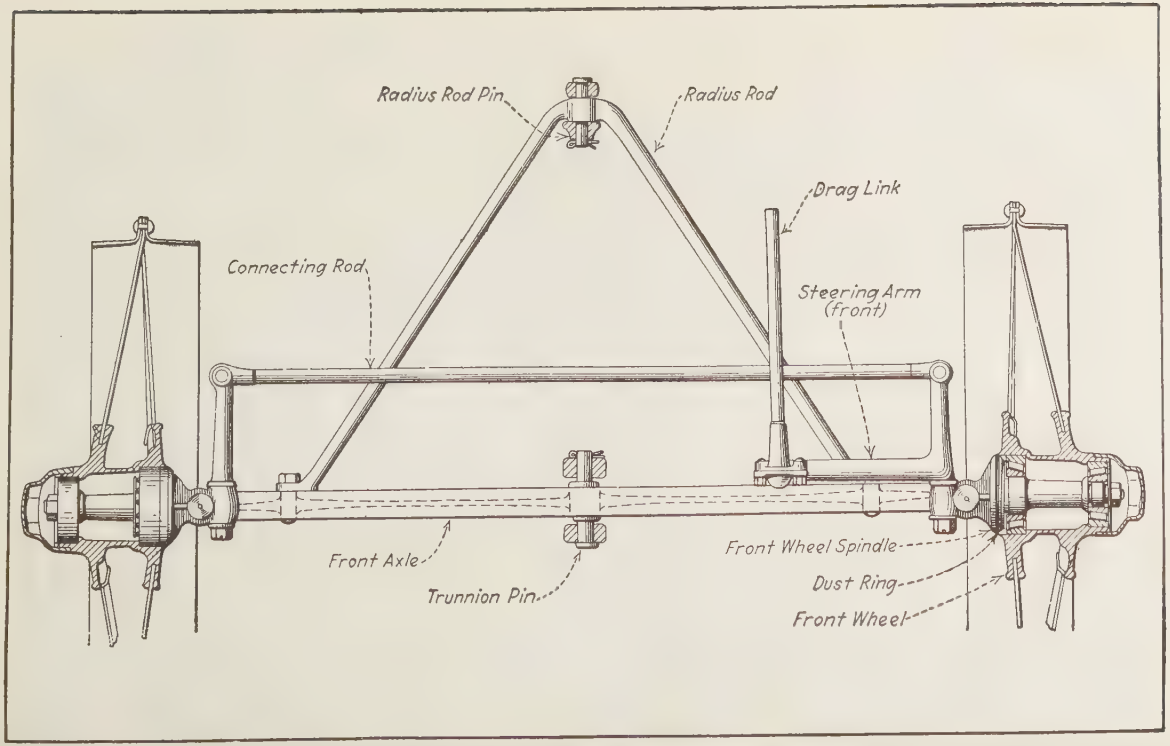


Fig. 129.—Plan View of the Front Axle of the Fordson Tractor, Showing Radius Rod, Steering Connections and Front Wheel Construction.

venient, it would be better to send such parts to a regular repair shop, where they may be properly straightened by fixtures designed for that purpose. It is very essential that the wheels line up properly, as improper alignments will cause defective steering and strain the parts.

Removing Front Axle.—Jack up the front of tractor so that wheels can be removed. Disconnect steering drag link from the steering arm—rear. Remove cotter pin from radius rod hinge pin and pull out pin. Remove locking cotter from trunnion pin and pull out that member. This releases the axle from the tractor. These points are clearly shown at Fig. 129.

Adjusting Front Wheel.—The adjustable front hub bearings are easily set up when too loose by removing the locking cotter from the adjusting nut on the end of the wheel spindle and tightening up that member until there is no shake in the wheel bearings and yet the wheels revolve freely. The axle should be jacked up to do this and the nut locked after adjustment is completed, by again passing the locking cotter through the end of the spindle and the slot in the nut. The front wheel hub is clearly shown at Figs. 128 and 129.

Fitting Drag Link Ball End.—If the drag link ball end is loose on the ball on the steering knuckle arm, the bolts holding the cap may be removed, to release the cap and the surface of the cap filed so it will fit more tightly against the ball. This cap and its bolts are clearly shown at Fig. 128.

Dismantling Rear Axle.—The rear axle shafts, worm and the differential assembly may be removed from the axle as a unit and afterward dismantled as shown at Fig. 131. To do this, it is first necessary to remove the wheel, then the dust cap. The flange at the end of the

axle housing is bolted to the differential housing and when these retaining members are taken out, the axle housing may be pulled off of the axle shaft and away

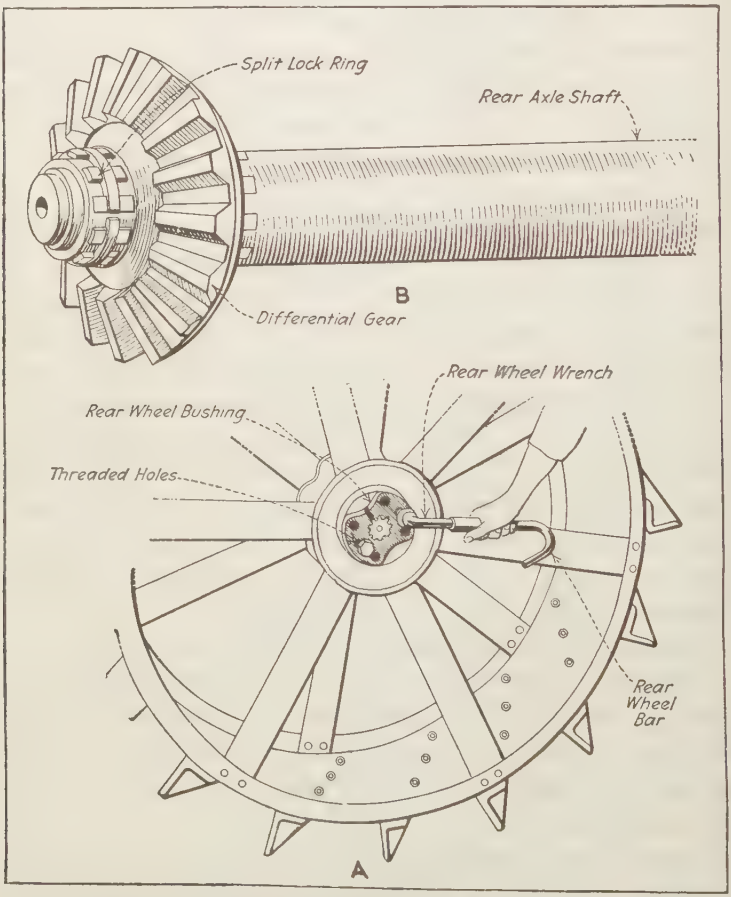


Fig. 130.—Diagram Showing the Method of Removing Fordson Tractor Rear Wheel at A and Differential Bevel Gear at B.

from the differential. After both housings are removed, the differential and axle shaft assembly may be taken

out. Two men are needed, one at each shaft end. The worm gear is lifted out of mesh with the driving worm and by tilting the differential assembly by lifting up one shaft end and bearing down on the other, it may be removed from its housing. The two halves of the differential casing are separated by releasing the bolts which clamp them to the worm gear. The appearance when dismantled is shown at Fig. 131.

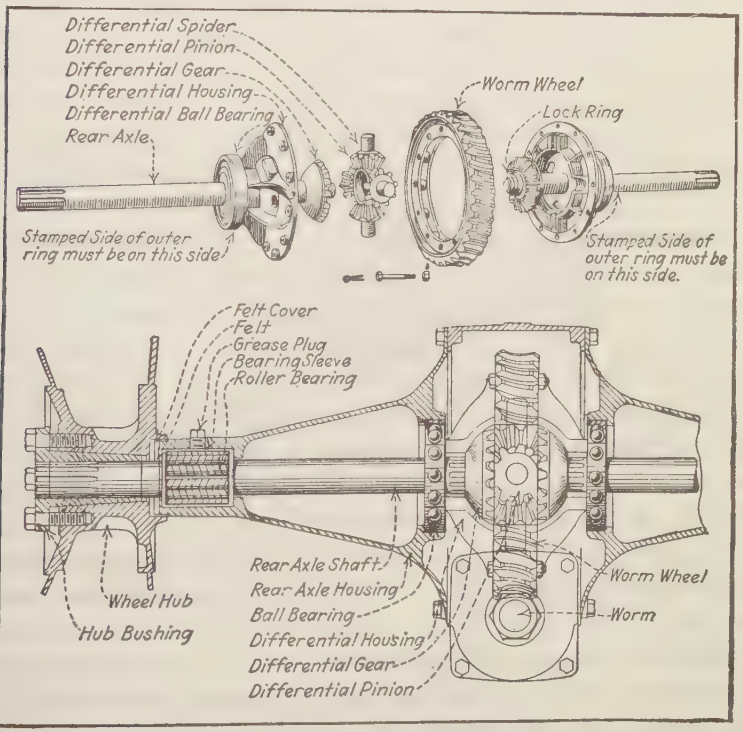


Fig. 131.—Phantom View of Fordson Tractor Axle at A Showing Ball Bearings Used for Supporting Worm Driving Gears and Differential Assembly and Roller Bearing at Wheel End of Axle. At B the Parts of the Differential Mechanism are Shown as They Appear When This Assembly Is Removed from the Axle.

Removing Differential Gear from Shaft.—(1) Press the gear back along the shaft until the split locking ring is exposed. (See Fig. 130.) (2) Remove the ring and press the gear off the shaft.

Removing Wheel.—(1) Jack up the rear axle until the wheel is clear of the ground. (2) Remove the four bolts from the hub using the box wrench and bar sent in the tool box. (3) Then insert two of the bolts in the tapped (threaded) holes of the rear wheel bushing; tighten up the bolts evenly until the wheel is free on the bushing. (4) Apply the hooked end of the bar to the flange and force the bushing off the axle. When replacing the wheel the four screws are inserted in their respective holes and tightened up equally, the ends of the rear axle being kept flush with the outside of the bushing.

Roller Bearings Need Oil.—The roller bearings at each end of the rear axle housing as outlined at Fig. 131 should be well lubricated by occasionally removing the plugs and inserting heavy fluid gear oil. The felt washers which protect them from dust and dirt need replacing when dirty or badly worn. To do this remove the rear wheels. The felt washer is inside the steel cover on the end of the housing. This can be removed by prying it off with a screw-driver. When replacing the felt cover, the edge should be bent into the groove in the end of the rear axle housing to prevent it from coming off.

How to Remove Transmission.—As the transmission gears are hardened and the shafts run on ball bearings, there will be practically no wear if they are kept free from grit and well supplied with a good grade of oil. No adjustments are provided or are necessary. If the bronze bushing in the reverse gear wears in time, it

should be replaced by a new bushing. If an attempt is made to change gears without first disengaging the clutch it will chip or break the ends of the gear teeth. Should this happen the transmission should be taken apart and washed out with kerosene to remove any particles of steel which would damage the gears or bearings.

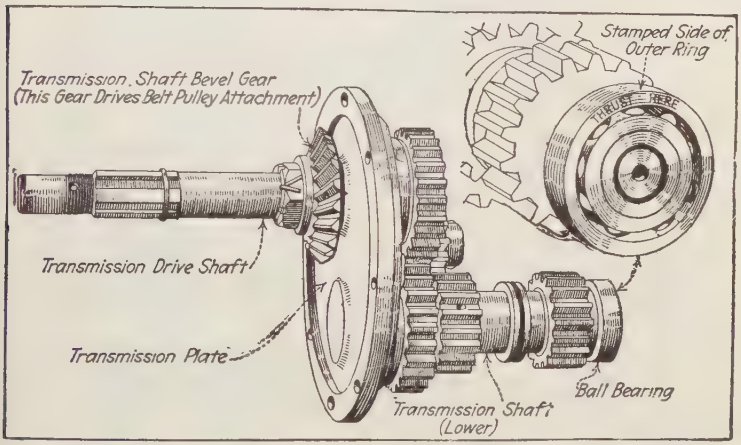


Fig. 132.—Transmission Plate and Gear Shaft Assembly Removed from the Fordson Tractor. Inset Shows Method of Installing Ball Bearings if These are Removed from Gear Shaft.

After removing the rear half of the tractor from the motor as previously described proceed as follows: (1) Drain the oil from the transmission housing by removing the drain plug just under the gear shifter cover. (2) Remove the gear shifter cover by unscrewing the four cap screws holding it to the transmission housing. (3) Unscrew the clutch drum nut from the end of the transmission drive shaft and draw off the clutch. (4) Remove the eight cap screws holding the transmission plate; then by pulling on the drive shaft, the plate to-

gether with the lower transmission shaft can be removed from the housing in one unit as shown at Fig. 132. (5) Remove the upper transmission shaft with its gears.

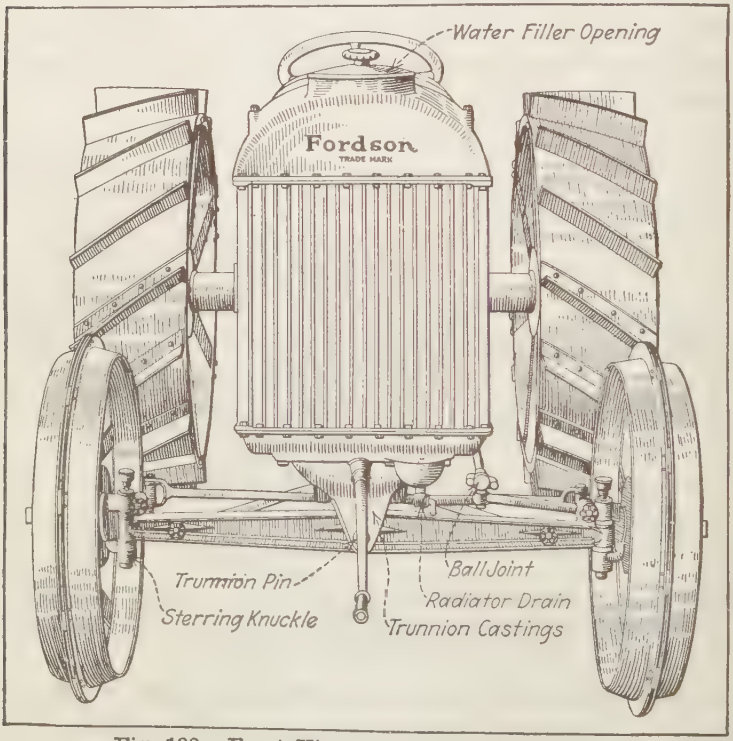


Fig. 133.—Front View of the Fordson Tractor.

Before replacing the gears in the housing clean them well with kerosene; the housing should also be flushed out with kerosene to remove any grit or gummed oil. Also clean and examine all ball races. If it has been found necessary to remove the ball bearings be very careful in assembling them on the shafts again, that

they are replaced in exactly the same position as before removing, i.e., the stamped face of the outer rings must face towards the ends of the shafts as shown at inset in Fig. 132. The inner ring of the bearing is pressed on the shaft while the outer ring slips into its seat when the parts are being assembled.

Timing Fordson Tractor Motor.—In timing the motor the points of opening and closing of the valves are, of course, what should be considered. As the valves are properly timed when the motor is built, the necessity for retiming would occur only when such parts as the cam shaft, time gears or valves are removed in overhauling the motor. In fitting the large time gear to the cam shaft it is important to see that the first cam points in the direction opposite to the zero mark. (See Fig. 135.) The time gears must also mesh so that the tooth marked with a zero on the small time gear will come between the two teeth on the large gear at the zero point. The time gears now being properly set, the exhaust valve on No. 1 cylinder is open and the intake valve closed, the other valves being in the position indicated in Fig. 135. The opening and closing of the valves is as follows: The exhaust valve opens when the piston reaches ¼ inch of bottom center, the distance from the top of the piston head to the top of the cylinder casting measuring 4-11/16 inches. The exhaust valve will close on top center, the piston then being 1/16 inch above cylinder casting. The intake valve opens 3/64 inch to 1/16 inch after top center, the distance from top of the piston then being from 1/64 inch to level with cylinder casting and closes 7/16 inch to 15/32 inch after bottom center, the distance from the top of the pistons to the top of the cylinder

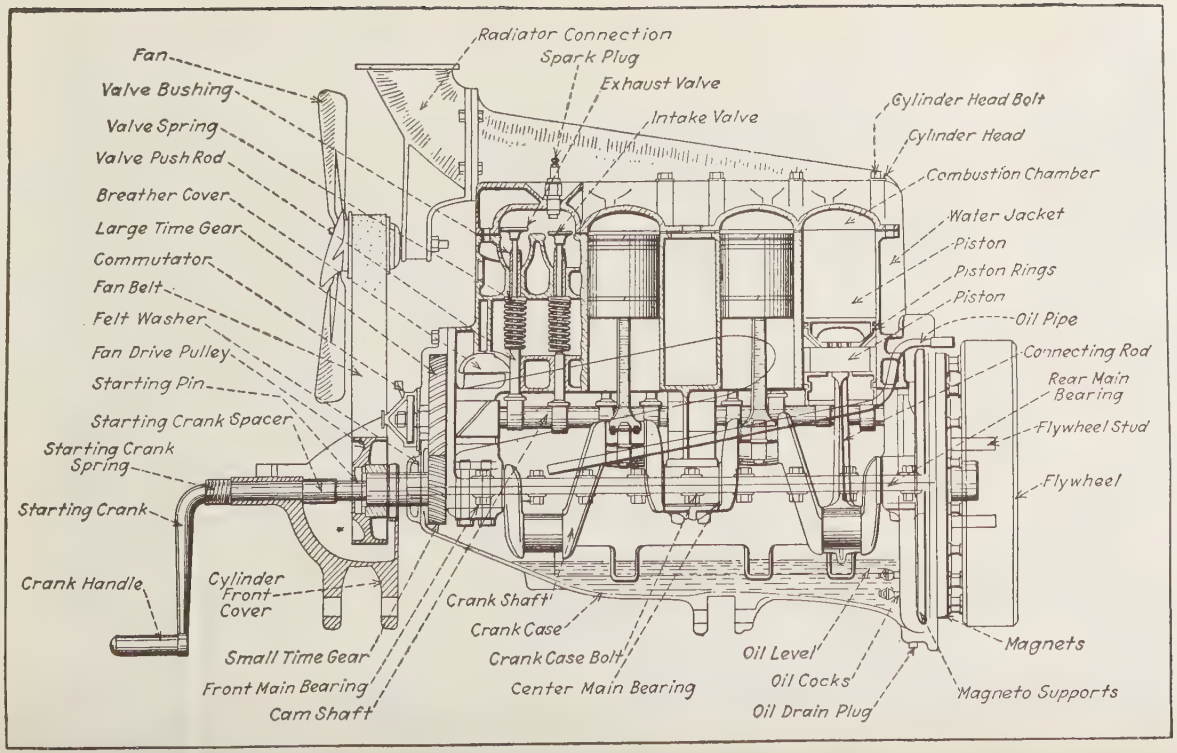


Fig. 134.—Phantom View of the Fordson Tractor Engine Showing Relation of the Various Parts Comprising the Power Plant Assembly

SUMMARY OF MOTOR TROUBLES AND THEIR CAUSES.

(a) Motor Fails to Start.

1. Gas mixture too lean or poor grade of gasoline.
2. Water in fuel.
3. Vibrators adjusted too closely.
4. Water or congealed oil in commutator.
5. Magneto contact point obstructed with foreign matter.
6. Gasoline supply shut off.
7. Lack of water in air washer.
8. Water frozen in bottom of gasoline tank.
9. Water or spark plug or wire terminals.

(b) Motor Lacks Power—Runs Irregularly.

1. Poor compression on account of leaky valves.
2. Imperfect gas mixture.
3. Spark plugs dirty.
4. Coil vibrator burned or improperly adjusted.
5. Air leak in intake manifold.
6. Weak exhaust valve spring.
7. Too great clearance between valve stem and push rod.
8. Spark plugs dirty or points imperfectly adjusted.
9. Commutator contact imperfect.
10. Burnt out vapor tube.

(c) Motor Stops Suddenly.

1. Fuel tank empty.
2. Water in fuel.
3. Dirt in vaporizer or feed pipe.
4. Magneto wire loose at either terminal.
5. Magneto contact point obstructed.
6. Overheated on account of lack of oil or water.
7. Gas mixture too lean.

(d) Motor Overheats.

1. Lack of water.
2. Lack of oil.
3. Fan belt torn, loose or slipping.
4. Carbon deposit in combustion chamber.
5. Spark retarded too far.
6. Gas mixture too rich or too lean.
7. Water circulation retarded by sediment in radiator.
8. Dirty spark plugs.
9. Lack of water in air washer.

(e) Motor Knocks.

1. Carbon deposit on piston heads.
2. Loose connecting rod bearings.
3. Loose crank shaft bearings.
4. Loose piston or piston pins.
5. Spark advanced too far.
6. Motor overheated.
7. Gas mixture too rich or too lean.

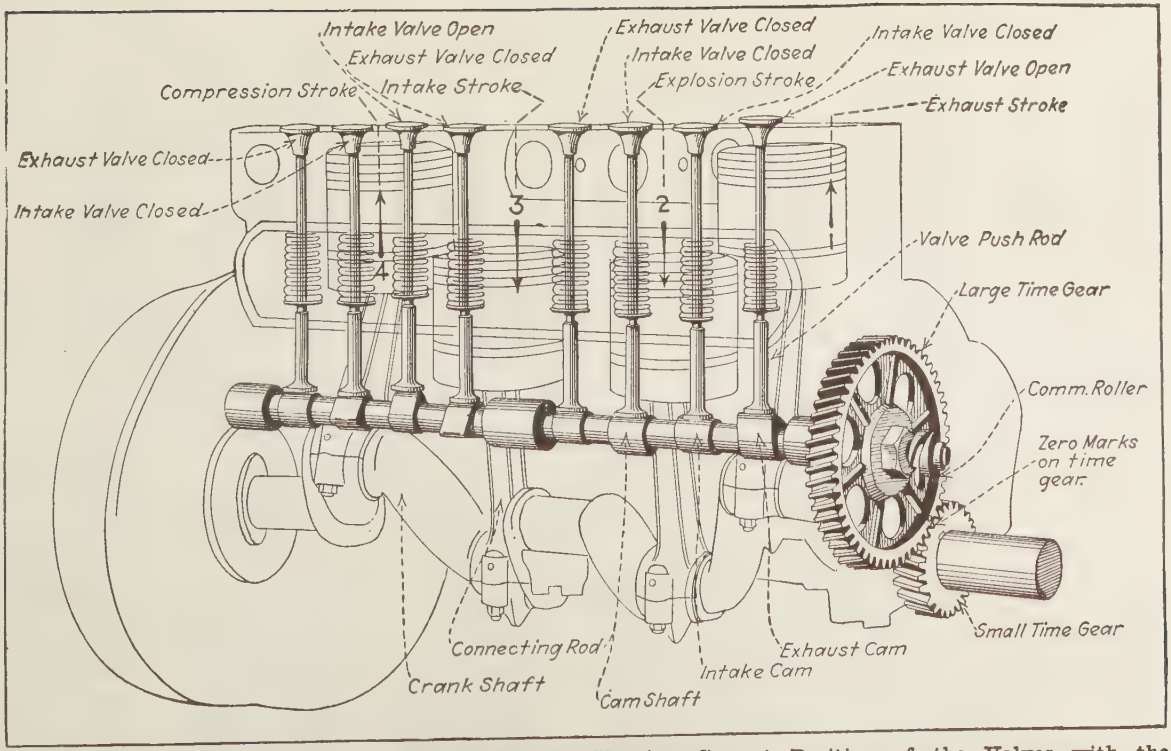


Fig. 135.—Diagran of Fordson Cylinder Assembly Showing Correct Position of the Valves with the Timing Gears Properly Set According to the Zero Marks on Gear Teeth, Also the Relative Position of Pistons in Their Strokes. The Firing Order of the Cylinders is 1, 2, 4, 3.

casting then measuring from 4-15/32 inches to 4½ inches. The clearance between the push rod and valve stem should be .020 inch and should measure this amount when the push rod is on the heel of the cam. When retiming, the opening of the intake valve and the closing of the exhaust valve are the points which should be observed.

Fordson Tractor for Plowing.—A self-lifting two-bottom plow is the proper outfit to use. The tractor will pull in plowing gear two 14-inch bottoms in average soil

Fig. 136.—The Fordson Tractor and Oliver No. 7 Two Bottom Plow at Work.

as shown at Fig. 136. The conditions, however, determine the size of bottoms to be used. The tractor must be able to do the work in plowing gear as it will not be found as economical to plow continuously in low gear. By using the self-lifting plow the driver can operate both the tractor and the plow from the tractor seat, as all operating levers are within easy reach. The

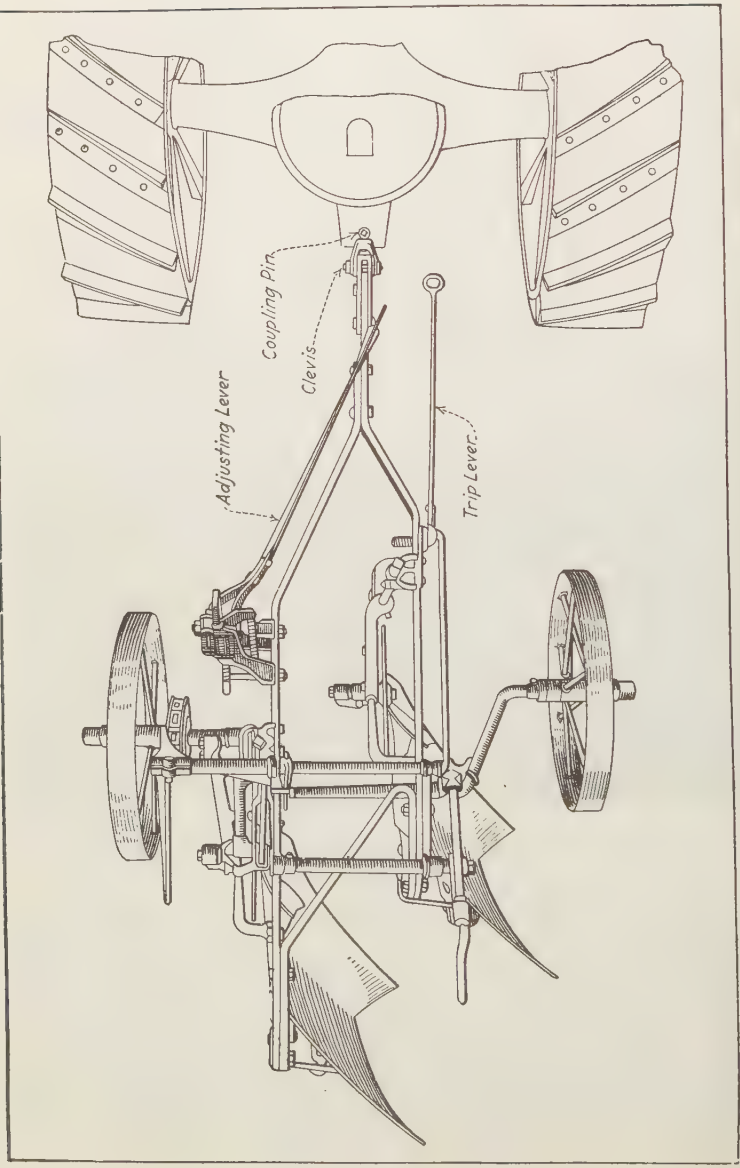


Fig. 137.—Plan View Showing Method of Attaching Two Bottom Plow to Fordson Tractor.

two wheel tractor plow is attached to drawbar cap, and can be readily backed when necessary. *Note—Never use chain hitch around rear axle housing.*

Attach the clevis shackle of the plow to the center hole of the drawbar cap of the tractor. This must be done without a chain or other flexible connections so that the plow can be backed up. (See Fig. 137.) The center of draft of the plow must be in line with the center of the tractor, otherwise difficulty will be found in steering

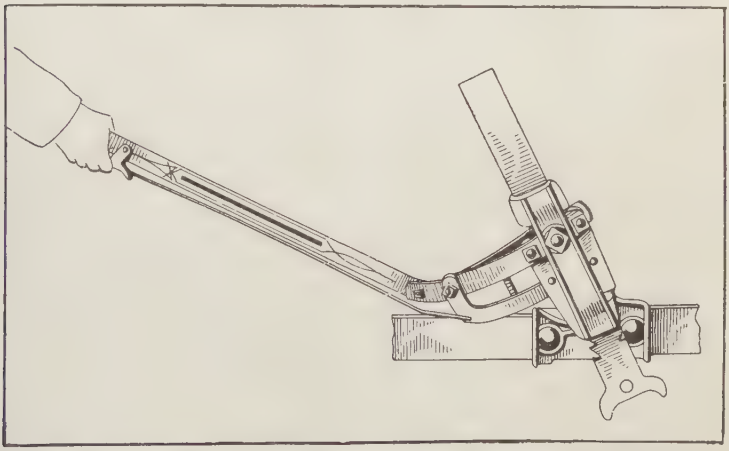


Fig. 138.—Showing Method of Raising and Lowering Plow Shares by Hand Lever Provided for That Purpose.

and a loss of power will result owing to side draft. The illustration at Fig. 137 shows the proper position of the plow behind the tractor.

The center of draft of the tractor lies midway between the two driving wheels. The center of draft of the plow lies about midway between the two bottoms; and when hitched to the tractor the center of draft of the plow and tractor will be in line and will run parallel

to the furrow. The right-hand front and rear wheel must be in the furrow. (See Fig. 136.) This brings the center of draft of the plow line with the center of draft of the tractor and eliminates all side draft and makes steering easy.

Adjusting Penetration of Plow.—The clevis plates have three holes in the rear for adjusting the penetration of the plow. The clevis plates should be so adjusted that

Fig. 139.—Illustration Showing How Fordson Tractor is Used to Pull Mowing Machine.

the bottom of the land side on the rear base will touch the ground slightly, or will be raised not more than one-half an inch off the bottom of the furrow when plowing. If the plow is hitched to low, it will not enter the ground quickly enough, and will cause unnecessary friction on the bottom of the land side. If it is hitched too high the bottoms will run on the points of the shares, caus-

ing wear and heavy draft. The proper time to make your final clevis adjustment is after you have opened up the land and the furrow wheel of the plow is running in the furrow.

The adjustment of the plow shares is varied by working the adjusting lever attached to the plow. When it is desired to plow deeper, grasp the end of the lever, at the same time pressing the hand latch firmly against

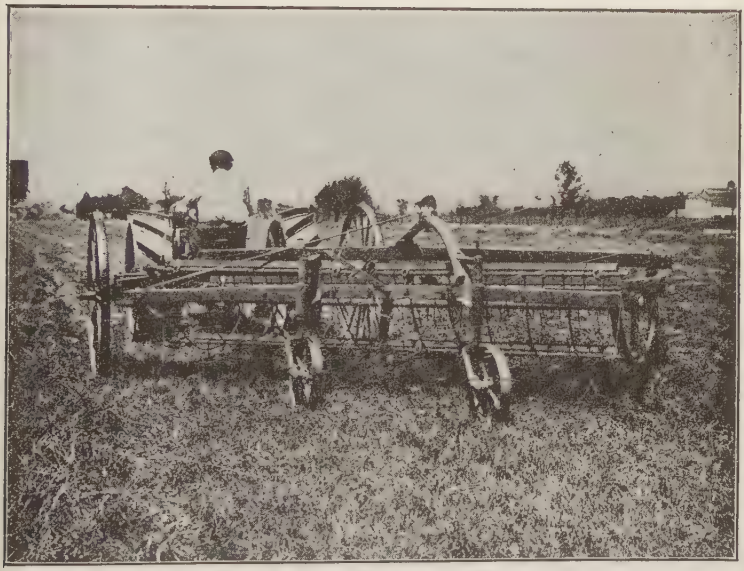


Fig. 140.—The Fordson Tractor May Be Used for Hauling the Hay Rake Advantageously.

the lever; then move the lever up and down. (See Fig. 138.) To plow shallower, move the lever up and down, but do not hold the hand latch.

As the tractor and plow wheels are on unplowed ground when opening land, it is necessary to have a different adjustment to the bottoms than that used after

the back furrow has been plowed. This is done by turning the screw crank in the rear of the plow. This adjustment depends on the depth of the furrow desired by the front bottom. After you have opened the land and the furrow wheel is running in the furrow, turn back the screw crank sufficiently to level the plow.

The plow is dropped or engaged by pushing the trip lever firmly downwards when the tractor has entered the

Fig. 141.—Fordson Tractor May Be Used to Assist in Loading the Hay and Also for Hauling the Hay Wagon to the Storage Barn.

furrow and the rear wheels have just passed off the headland. The plow may be dropped while in motion or when standing.

The plow is released by raising the trip levers attached to the plow when the rear wheels of the tractor

have just passed on to the headland. The trip lever is raised slowly until the plow begins to rise; the tractor being kept moving until the locking device engages.

The lie of the land and the shape of the field will determine the best method. When planning your plowing

Fig. 142.—The Fordson Tractor Used in Unloading the Hay Wagon after it Reaches its Destination.

avoid traveling with the plow out of the ground as much as possible. For making turns a headland of about twenty feet is required. When plowing hilly land it sometimes becomes advisable to hitch the clevis shackle

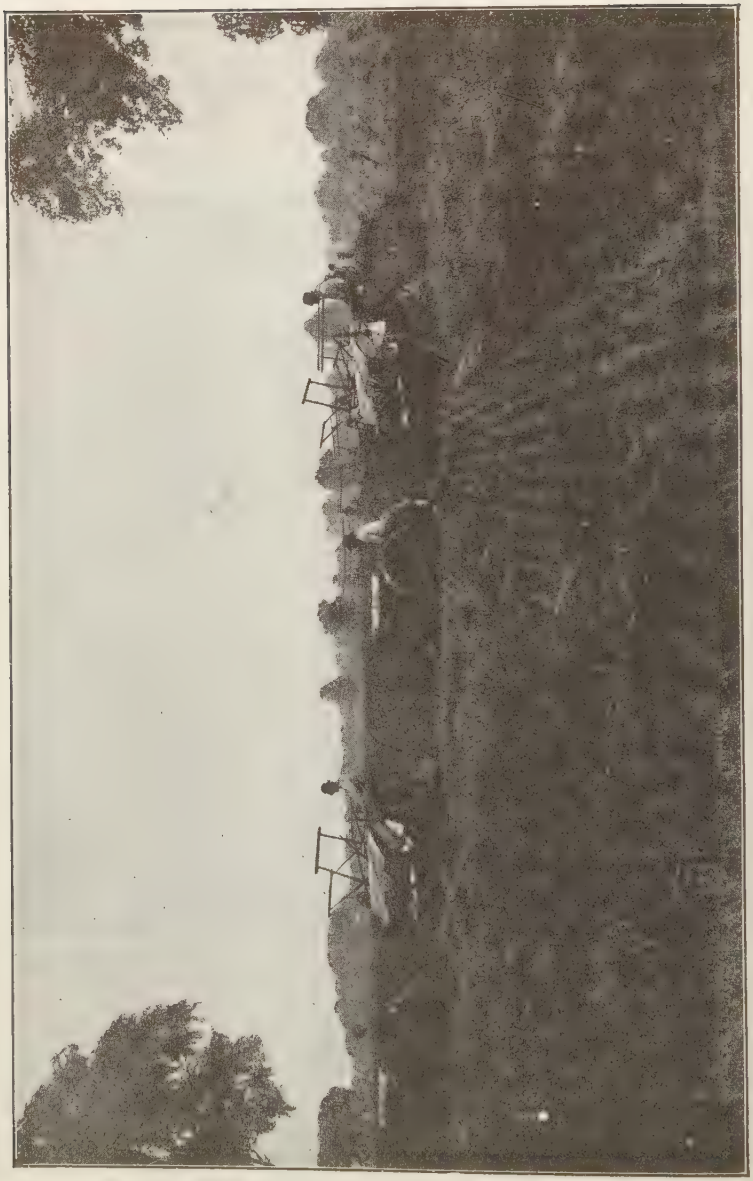


Fig. 143.—A Number of Fordson Tractors and Harvesting Machines Can Be Used Advantageously

into the holes on either side of the drawbar cap of the tractor in order to counteract the tendency of the plow to slide down hill.

Fordson Tractor Has Many Uses.—It is not only in plowing work that this tractor may be used to advantage, but in all kinds of draft and belt work as well. It not only prepares the ground for planting by plowing, harrowing and rolling it, but also harvests the crops. It may be attached to any agricultural machinery that can be hauled by animal power. It is shown at work harvesting hay in the series of photographs, Figs. 139 to 142 inclusive. It is attached to the mowing machine by a special tongue or pole, having bent iron pieces at the end to raise the pole to the proper angle, these being hitched to the drawhead by a simple coupling bolt.

In the illustration Fig. 140 the tractor hauls the hay rake and stacks up the hay in long windrows. The next operation is shown at Fig. 141, where the tractor is hitched to a hay wagon and loader to bring in the hay and after the wagon is towed to the barn it can be used to unload the hay from the wagon as shown at Fig. 142. As will be evident, it has successfully replaced horses in every operation except eating the hay, which can be fed to farm animals having a food value or producing food products instead of to animals useful only for draft purposes.

The Fordson tractor may be used to advantage in harvesting and threshing cereal grains, as shown at Figs. 143 and 144. The former shows its use for hauling combined mowing and binding harvesters; the latter shows its use "in the belt" for running a threshing machine as well as serving as a mechanical horse to bring the loaded wagons with sheaves of grain to the threshers.

Fig. 144.—How the Fordson Tractor May Be Employed for Driving a Threshing Machine by Suitable Belt Connection.

Combination Hitches.—When it is possible, several machines may be drawn at the same time to save going over a certain strip of ground more than once. This

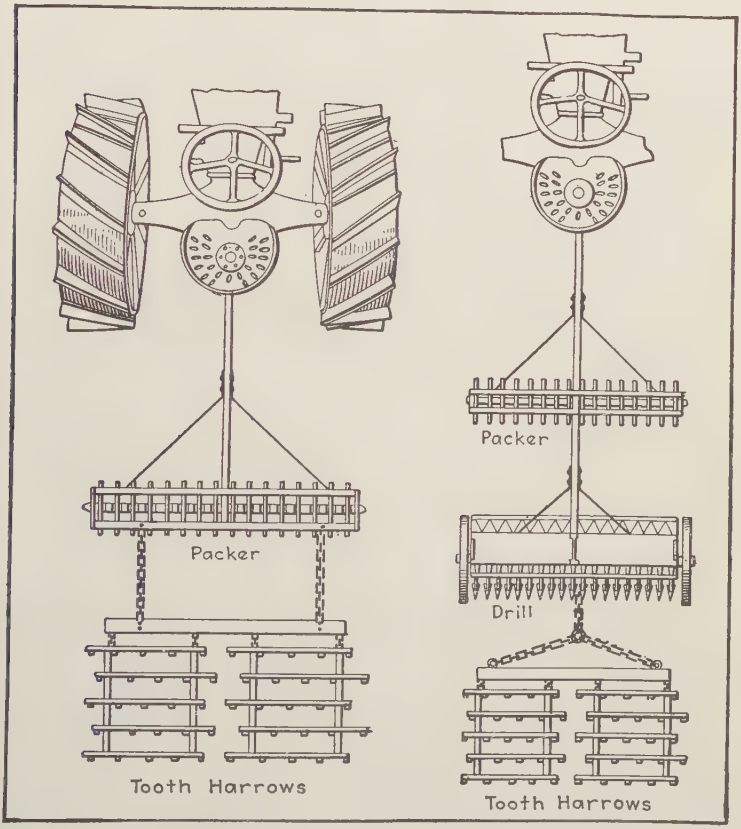


Fig. 145.—Diagram Showing Time and Labor Saving Combination Hitches.

applies only to such machines as have light draft and judgment must be used not to overload the tractor. Two combination hitches are shown at Fig. 145 that can be used in connection with the Fordson tractor. At A a

packer and tooth harrows are drawn by the tractor and the ground may be packed and harrowed at the same time. The hitch shown at B shows a seeder interposed between the packer and tooth harrows and a strip of ground may be packed, seeded and harrowed in one operation. Sometimes a stone drag packer may be pulled behind a disc harrow or plow on soil that does not require maximum draft of tractor in plowing.

Power Needed for Hauling.—A tractor used for hauling purposes does not need to be as powerful as one used in plowing or breaking because of the difference in draft required by wheeled vehicles and plows. The tractive effort on various surfaces, which means the amount of pull or push necessary to move wheeled vehicles on level roads as given by Norris, follows:

On rails or plates	5.16	pounds	per	ton	weight
Asphalt or hardwood	12.24	"	"	"	"
Macadam	30.60	"	"	"	"
Loose gravel	150 to 200	"	"	"	"
Sand	400	"	"	"	"

From the foregoing, it will be seen that the better the surface of the highways over which the load is hauled, the less the amount of power needed to move a definite weight. If it is necessary to haul a wagon train, weighing ten tons over a macadam road, it would require a draft of 306 pounds. To move the same weight through sand will take 4,000 pounds draft. It is stated that a horse-power is equivalent to a draft of approximately 187 pounds at the rate of two miles per hour. In the first case, where the highway surface is good, a drawbar pull equivalent to that exerted by two horses would be sufficient to pull ten tons. A 5 to 6 horse-power trac-

tor, if properly designed, would be adequate to move this load, provided that there were no grades or stretches of unfavorable highway to be encountered. At the other hand where the road conditions are poor, a pull equivalent to that exerted by twenty horses would be needed and a very efficient tractor equipped with a 35 or 40 horse-power motor would be called for, computing the drawbar horse-power as the equivalent of 50 per cent the brake horse-power of the engine. The Fordson tractor has sufficient drawbar pull to haul 60 tons on macadam or 5 tons in sand. It will pull 10 tons on a gravel road but its cleated wheels should not be run on hard surfaced roads because they would cut in. Other factors besides the condition of road surfaces must be given consideration. The factor of wind resistance, which is so important in figuring power required of motor cars, locomotives or other rapidly moving vehicles can be neglected but the effect of gradient and traction must be considered in this connection.

Energy Absorbed by Plows.—If the tractor is to be used for breaking and plowing it will have to be a powerful one if it is to do an amount of work worth while. Soils differ greatly in their cohesive properties and the amount of draft required to operate a single plowshare will vary within wide limits. The average draft of plows as determined in an old English test for a furrow 5 inches deep by 9 inches wide made in five different soils, was as follows:

Loamy sand	227 lbs.
Sandy loam	250 "
Moory soil	280 "
Strong loam	440 "
Blue clay	661 "

This represents an extreme range of 94 per cent. One heavy horse would be needed to pull a plow in sandy loam and in doing this he would be exerting a draft having a value greater than one horse-power. A team of two heavy horses would be needed to pull the shares

Fig. 146.—A Rear View of Fordson Tractor Showing Belt Connections Between Power Take-off on Tractor and Pulley on Threshing Machine.

through strong loam, while in plowing the blue clay three heavy or four light horses would be required to pull the plow continuously for a working day.

Fordson Horse-Power.—The motor develops twenty horse-power when running at 1,000 revolutions per

minute and using kerosene. It will maintain a drawbar pull of 1,800 pounds at plowing speed. In low gear a drawbar pull of 2,500 pounds is obtained. As the Fordson tractor power plant will develop its full brake horsepower when used in belt work it will be apparent that this engine may be used successfully for operating much of the machinery that must be run by belt. The utility of the tractor for this purpose is clearly indicated at Figs. 146 and 147. The tractor is run to where the work is to be done and a simple belt connection with any machine serves to drive it.

The power needed to operate various forms of machines under belt as given by the International Harvester Company follows:

4-Roll Deering Husker and Shredder	12
6-Roll Deering Husker and Shredder	15
4-Roll McCormick Husker and Shredder	12
6-Roll McCormick Husker and Shredder	15
24″ x 40″ Thresher	15
28″ x 44″ Thresher	20
4-Hole Keystone Sheller	12
6-Hole Keystone Sheller	12

From the above, it will be evident that there is considerable machinery that can be operated by the tractor. It may be belted to a circular saw for sawing wood and can also be utilized for running feed grinders, ensilage cutters and numerous other farm appliances that require power within the engine rating. It will be well to limit the engine when "in the belt" to driving machinery that does not require in excess of 15 horse-power, because there is a certain power loss in power take-off and driving belt.

Fordson Power Take-Off.—The "Fordson" belt pul-

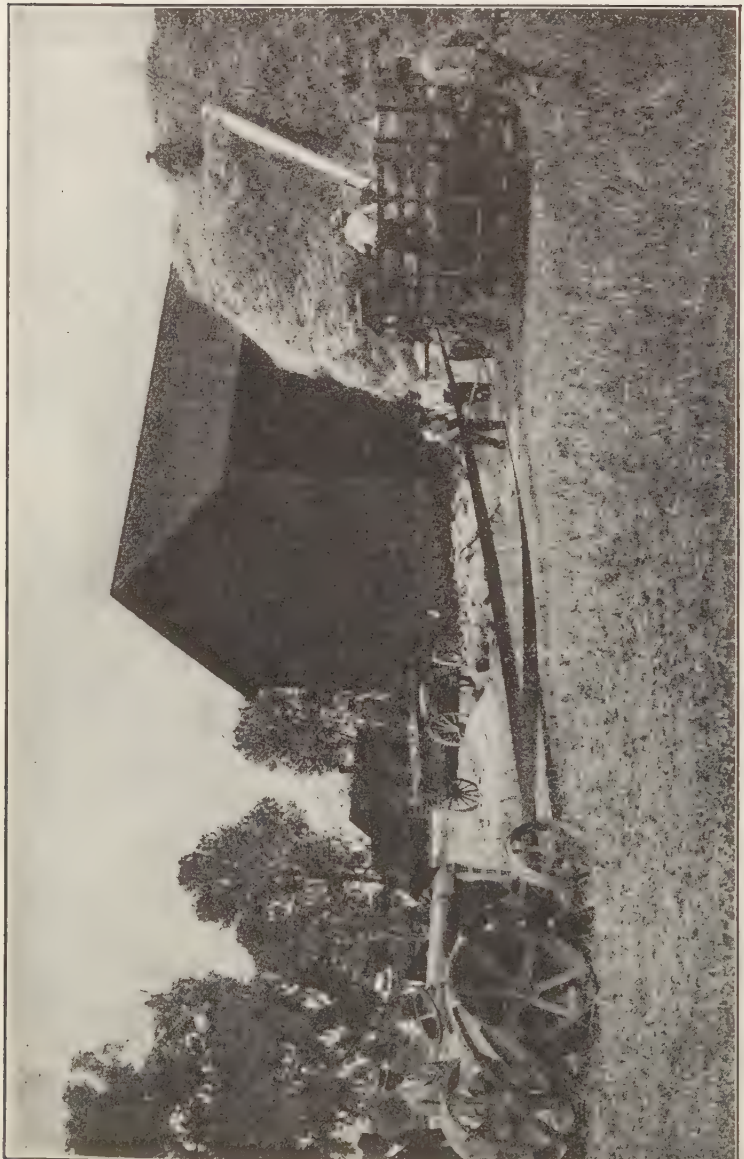


Fig. 147.—Side View Showing Method of Driving Threshing Machine by Belt Power Indicates That a Long Belt May Be Run Slack

ley and power take-off is furnished as an accessory and was designed especially for use with the Fordson tractor to operate such pulley driven implements as grain separators, silo fillers, hay balers, feed grinders, corn huskers, buzz saws, etc. The pulley is driven direct from the motor through the drive shaft and spiral bevel gears, and runs at the same speed as the motor. The location of the drive gears is clearly shown at Fig. 125 and the pulley assembly and its parts at Fig. 148.

When the motor is running at a speed of 1,000 revolutions per minute, the pulley will develop approximately 20 horse-power, which is sufficient for operating practically all medium-sized farm machinery. The drive pulley is constructed of special paper fiber, which requires no refacing, and prevents slipping of the drive belt. The drive pulley is nine and one-half inches in diameter, six and one-half inches wide and is slightly crowned to insure the drive belt running in the center of the pulley at all times.

Installing and Using Belt Pulley Attachment.—(1) Place jack under drawbar cap, slightly toward the right-hand side. Jack up the tractor sufficiently to remove the right wheel, first making sure that the tractor is properly blocked before removing it.

(2) Remove foot bracket, and satisfy yourself that the tractor is equipped with transmission drive shaft spiral bevel gear. This is the gear that drives the pulley attachment and must be installed before the pulley can be operated. If you find that this gear is not installed you can procure one (free of charge) from your nearest dealer.

(3) Install pulley attachment assembly so that the hole in the pulley housing is in a downward position,

to let the lubricating oil drain back into the transmission.

(4) Two paper gaskets are provided with each pulley attachment and are to be applied before bolting the pulley housing to the transmission case.

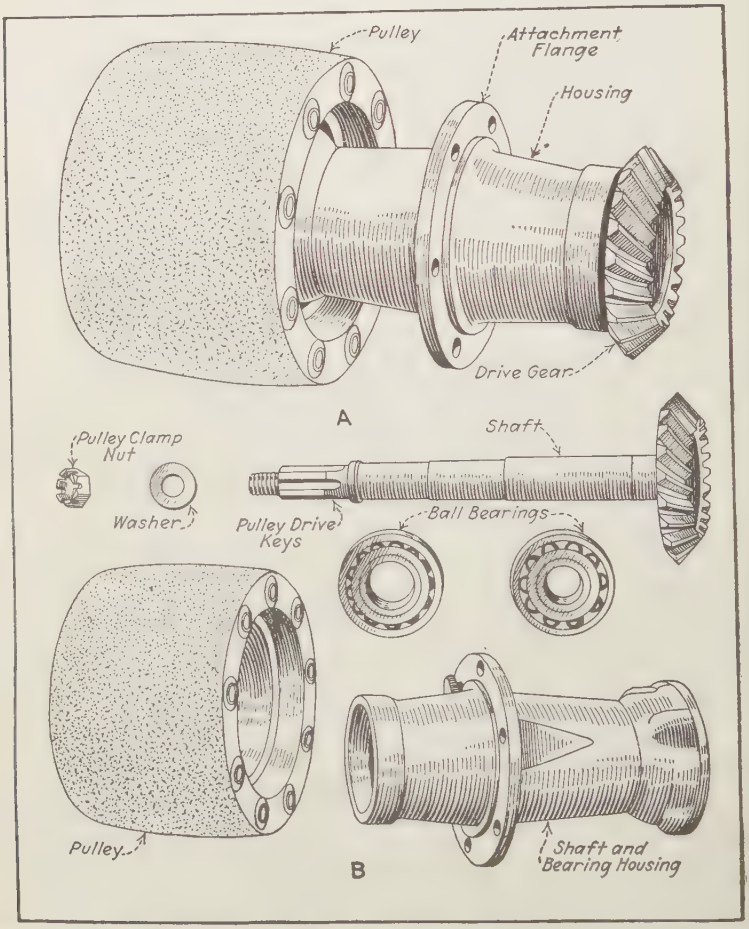


Fig. 148.—The Fordson Tractor Power Take-off or Driving Pulley Attachment Shown at A, and the Various Parts Used in This Assembly are Depicted at B.

(5) After tightening up the six cap screws, hold the pulley between the two hands and make sure that there is a slight play or back lash between the two gears; otherwise a grinding noise will be noticed while running which indicates that the gears are too tightly meshed. Operating in this condition will cause the premature

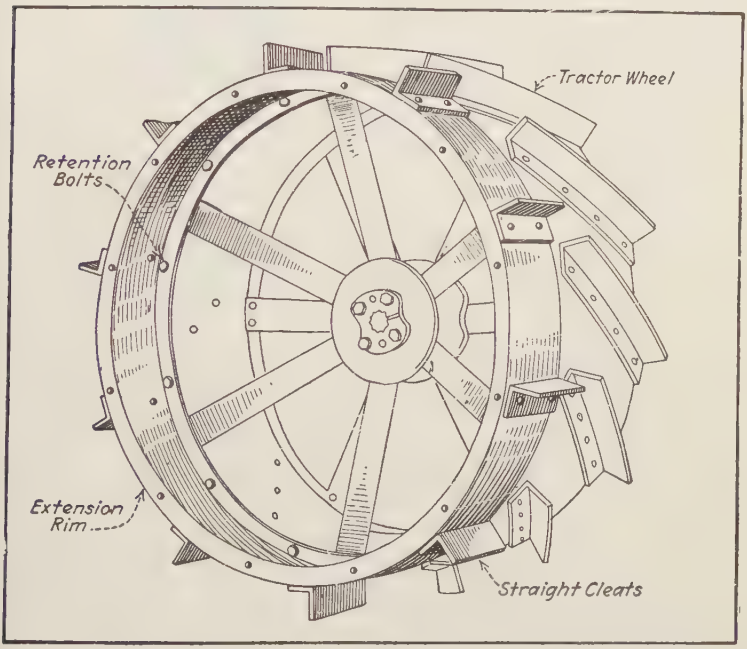


Fig. 149.—The Extension Rim That May Be Applied to Fordson Tractor Wheels When Tractor Is Used on Soft Soil or Where Traction Conditions Demand More Wheel Support.

wearing of gears and ball bearings in addition to consuming more power than is required. After installing pulley attachment, if the gears are meshed too tightly, a third gasket should be applied. This can be made from ordinary wrapping paper.

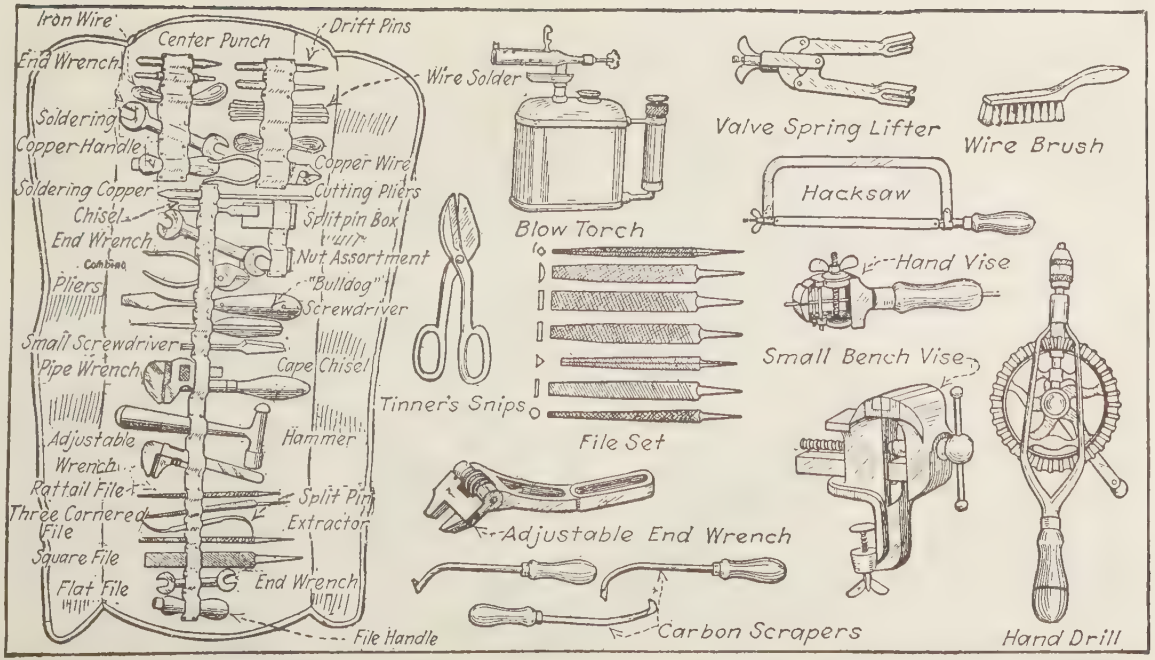


Fig. 150.—Tool Equipment That May Be Used to Advantage in Repairing Either Automobiles or Tractors.

(6) In cranking the engine after the belt has been applied, see that the clutch pedal is held down, or difficulty will be experienced in turning over the motor.

Extension Rims.—As shown in the illustration at Fig. 149 these can be fitted to the rear wheels for working on sandy or unusually light soil. They will give the tractor sufficient support and traction to work even under these conditions. When plowing the extension rim should be applied to the landside (left) wheel only. When fitting the land both wheels can be equipped. Extension rims are 7 inches wide and have 10 cleats riveted on. They are drilled for bolting to the flanges of the rear wheel. Necessary bolts and nuts are furnished with the rims.

These extension rims are not part of the regular equipment, but can be supplied as an accessory by the dealer.

Tools and Equipment for Care of Tractor.—The farmer who intends to take care of his own tractor or one who has several of these machines will find need for a number of tools of a slightly different character from those generally used in repairing farm implements. A set of small tools most likely to be used should be carried on every tractor, as often repairs of a minor nature must be made in the field. In the illustration (Fig. 150) a comprehensive outfit of small tools and devices that will be found especially valuable in making repairs for the tractor engines or transmission system are outlined. The tool roll contains an assortment of tools that are more generally used and is a modified form of the tool kit generally supplied for automobile repairing. The only difference between the tools is that these are larger and more substantial in order to handle the more rugged

parts of the tractor mechanism. The tool roll shown contains all necessary wrenches, pliers, screw-drivers, punches, drift pins, chisels and files as well as miscellaneous supplies necessary to make ordinary repairs. The tools shown at Fig. 151 are those supplied with the Fordson tractor.

In addition to the tools outlined a small bench vise that can be attached to any convenient point on the trac-

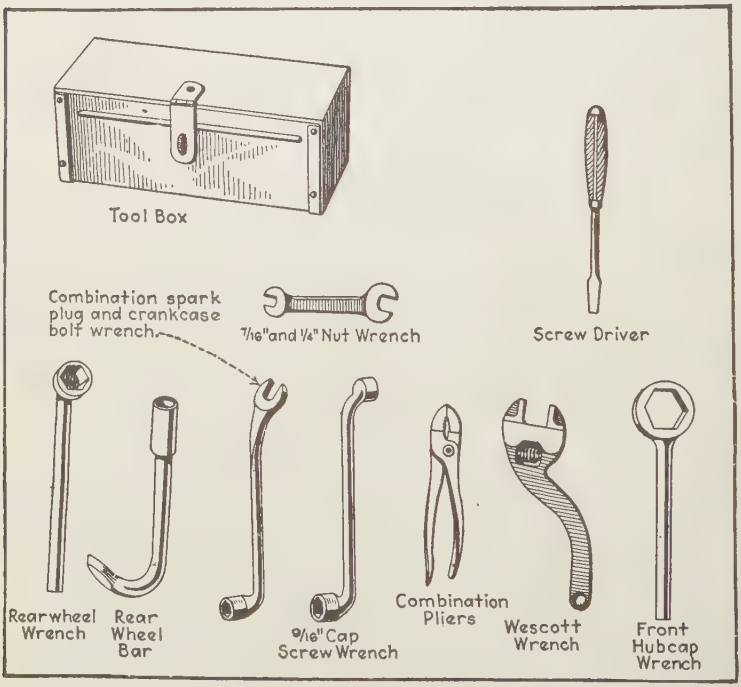


Fig. 151.—Tool Outfit Supplied with the Fordson Tractor.

tor will be found of considerable value. The large file assortment may be kept at the workshop for use in making more extended repairs. This is true also of the

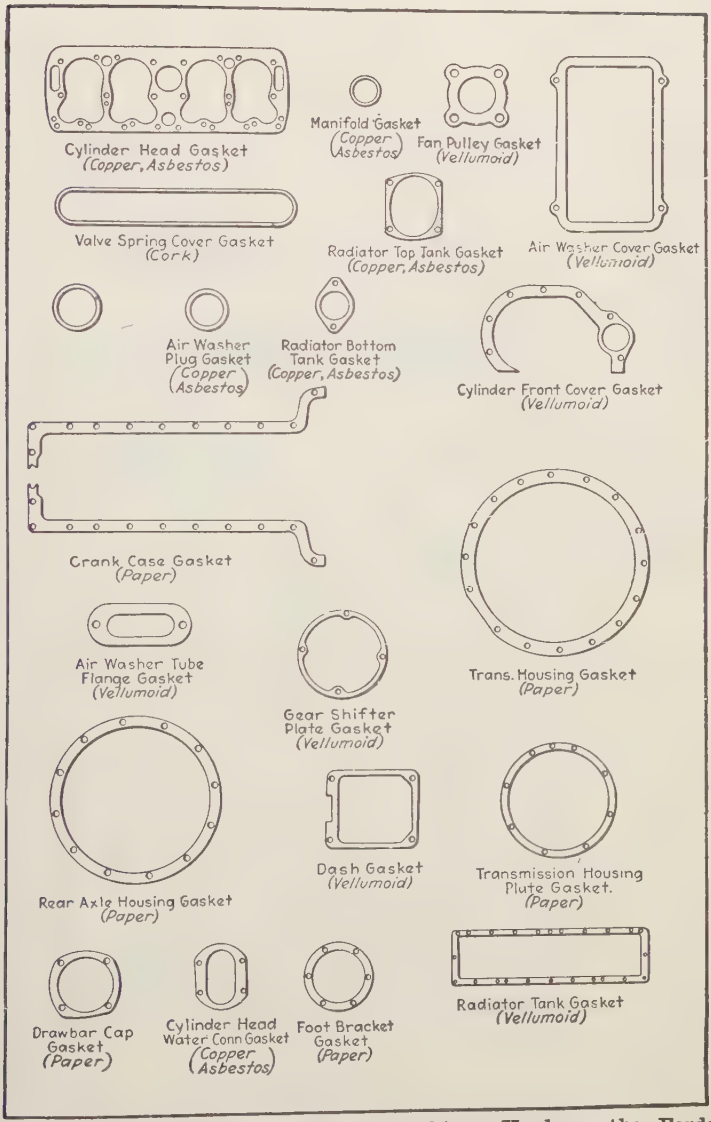


Fig. 152.—The Various Gaskets and Packings Used on the Fordson Tractor and the Material of Which They Are Made.

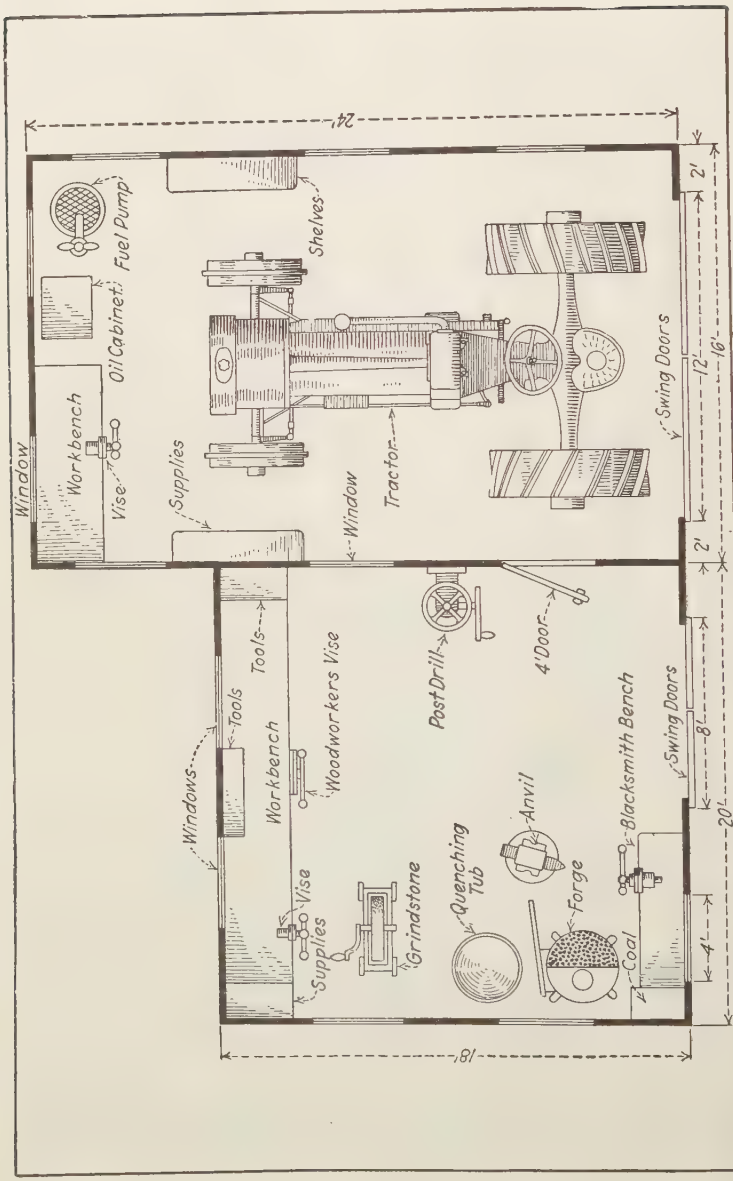


Fig. 153.—Plan View of Combined Tractor House and Automobile, Carriage and Farm Machinery Repair Shop.

carbon scrapers, the valve spring lifter and the hand drill. The hacksaw, hand vise and tinner's snips occupy but little room and can be conveniently stored away in the tractor tool box. The blow torch will be found very useful in providing a source of heat for the soldering iron and for loosening rusted-on nuts and for many other purposes that will suggest themselves. Among the general supplies that should be included in the equipment are spare spark plugs for the motor, a few feet of primary and secondary electric wire, material to make the various gaskets and packings used on the engine, a quantity of cotton waste or old rags, an emergency supply of cylinder oil for the engine and cup grease for the grease cups. The other supplies or spare parts needed will vary with the use given the tractor and the distance it is to be operated from a base of supply. The various gaskets used are illustrated at Fig. 152.

Combined Tractor House and Farm Workshop.—There is an important point in which the average farmer is somewhat lax and that is providing himself with a shop of adequate size and with suitable equipment to make ordinary repairs on the various farm appliances. The farm that is up-to-date enough to own a gas tractor also has one or more automobiles and should be sufficiently progressive to provide a well-equipped shop where not only the tractor can be repaired but the other vehicles and farm tools receive attention when needed. A very satisfactory method of doing this is to make a combined tractor house and farm workshop as outlined at Fig. 153. While one is putting up the garage for the tractor, it does not prove much more expensive to enlarge the structure somewhat and have a separate room in

which the various tools needed to do wood work and metal work, such as smithing, can be housed and which can also be used as a garage.

It is not expected of the average farmer that he qualify as a blacksmith or machinist, but at the same time there are many little tasks that he can do just as well as the blacksmith or wagon builder that will not only save money by providing work for a period of leisure when conditions do not permit outside work to be carried on but that may also save valuable time during the rush period of plowing, seeding, or harvesting, by saving a trip to town.

A shop may be equipped with all necessary wood and metal working tools to make ordinary repairs for considerably less than $200. This includes a complete set of carpenter's tools, a forge and blacksmith's outfit, and the various small tools necessary to properly care for the tractor or automobile engine. The plan shows a tentative layout that may be followed to advantage but that can be varied at will. In this the workshop is provided with a long bench at the back end, a portion of which is reserved for wood work, while the remainder is convenient to forge and anvil. An 8-foot door is provided so any automobile or farm wagon or other appliance may be run into the building when it needs repairing and be worked on in comfort. While general dimensions are given, these and the arrangement of tools may be varied to suit individual requirements.

CHAPTER IX

USEFUL INFORMATION FOR REPAIRMEN AND OWNERS

Useful Notes for Ford Repairmen—Dimensions and Clearances—When to Renew Worn Parts—Permissible Wear and End Play—Starting the Ford Engine in Cold Weather—When Oil is Too Stiff—Ford Cooling System in Winter—Anti-freezing Solutions—Carburetor for Ford 1925 Models and Its Adjustment—Late Ford Ignition System—Ford Model T Starting and Lighting System—How to Focus Headlights—Roller Bearing Front Wheels—Adjustment of Taper Roller Bearings—Late Ford Motor Improvements—New Fordson Tractor Changes—Schedule of Standard Repair Charges—Engine Division—Rear System Division—Rear Springs—Front System Division—Front Springs—Chassis Division—Dash Assembly—Steering Gear—Muffler—Gas Tank and Line—Radiator—Wheels—Paint Division—Body Division—Top and Windshield Division—Lamp and Horn—Truck Chassis and Rear System—Starting, Lighting and Ignition Division—Battery.

Useful Notes For Ford Repairmen.—When aligning front wheels, remember that the camber or outward flare of the wheels at the top is 3 degrees, but this will not be disturbed unless the axle has been bent and re-straightened. The gather or toe-in ranges from ⅛″ to ¼″ and is adjusted by altering the position of the yoke on the left end of the connecting rod or the rod joining steering spindle arms. A bent tie rod will alter this dimension, which is measured by taking the distance between the wheels at the front. Ford front axles are also tilted back at the top 5½ degrees to give a castor effect, which is about ¼″ back tilt at top of steering spindle.

After reassembling a Ford car, one gallon of oil should be put in the motor, four ounces of light grease in the universal joint and one and one-quarter pounds in the

differential case. Be sure to grease front and rear wheel bearings well when assembling. Do not neglect the front motor support or the wishbone ball joint. The slow speed pedal should have from 1⅝″ to 1¾″ throw, so no trouble will be had in securing a neutral position when hand lever is set about half way of the quadrant. It is possible to set the timing without recourse to a gauge by remembering that the actuating rod connection on top of the timer case should be ¼″ past the central point on the fan bracket bolt. In replacing spindles be sure to have left hand threads on the right wheel and right hand threads on the left wheel, because if the precaution is not observed, the adjusting nuts may have a tendency to loosen up.

The following cotter pin sizes are used in the chassis parts: on the U bolts 3/32″ dia. by 1″ long. On the connecting rod or drag link and tie rod 3/32″ by ⅝″ long, on the spindle and spring perches 3/32″ by ¾″ long. A single size 3/32″ diameter by 1″ long can be used at all these points. All ⅜″ nuts or studs throughout the assembly use 1/16″ diameter by ½″ or ⅝″ long. The brake rods use 3/32″ by ½″ while the rear axle shaft nuts are ⅛″ diameter by 1″ long.

After boring and reaming, the cylinder bores vary from 3.748 inches to 3.749 inches and they are then burnished to the standard size of 3.750 inches. The pistons vary in length from 3.808 inches to 3.817 inches and are 3.748 inches diameter at the skirt. This is only .002 inches smaller than the bore. At the second ring more clearance is provided, this ranging from .005 inch to .007 inch, while at the top ring the piston should be .010 inch to .012 inch smaller than the piston bore. The ring grooves are ¼″ wide by 13/64″ deep. The piston pin

bushings are .741 inch diameter, the wrist pin is .740 inch diameter or about .001 inch smaller. Piston pins should not be fitted any freer than that. The top ring of the piston has .003 inch gap when compressed, the middle ring a gap of .005 inch, while the lower ring may have a gap of .008 inch.

The end play of the crankshaft, which is determined by the width of the rear main bearing, should not be more than .004 inch and all lengthening due to expansion from heat should be forward of the rear bearing. Any change in the opposite direction would affect the gap between coils and magnets. The front and center main bearings may have from 1/32″ to 1/16″ end clearance to allow for expansion. The crankshaft bearings are from 1.248 inches to 1.249 inches diameter. The crankshaft is 25 and 5/32″ long. The connecting rod big end bearings are 1.495 inches to 1.505 inches long. The diameter of all bearings are 1.248 inches with a standard undersize of .010 inches for main bearings. The distance between the outside of the crankshaft at the front of the engine and edge of the camshaft bearing should be 5.220 inches with an oversize permissible of .002 inches and an undersize limit of .003 inches. If the distance is measured when crankcase is cold it should be 5.218 inches with the same limits allowed as above. The expansion when the case is heated is .002 inches.

The camshaft is 22 23/32″ long. The dowel holes in the flange vary from .3120 inches to .3125 inches diameter. When the heel of the cam is in contact with the push rod a clearance of .022 inch to .032 inch should exist between the valve stem and push rod. The lift of Ford valves is 7/32″. The tension of valve springs ranges from 18 to 22 pounds. There should not be more than .002 inch play

in camshaft bearings. There should be from .002 inch to .005 inch back lash between teeth of timing gears.

The standard gear ratio of Ford cars is 3 7/11 to 1. For heavy pulling it is possible to secure gears giving a ratio of 4.2 to 1, while for speed work one can obtain ratios of 3 to 1. With standard ratio on the slow speed the rear wheels turn once to every ten of the motor. On high speed or direct drive, the engine turns 3 7/11 times to one revolution of the rear wheels. On reverse, the engine turns 14 6/11 times for every revolution of the driving wheels. In repair work three sizes of piston may be used, depending on the length of time the engine has been in use. Standard pistons if bores are not worn unduly with an oversize of .0025 inch. Others are .0315 inch and .033 inch oversize. Piston rings .031 inch oversize are used in repair work sometimes.

In axle repair work certain clearances are permissible. Where the yoke of the universal fits into the ring a play of .005 inch is allowable, but the rings must be tightly riveted together. There can be .003 inch play between drive shaft and supporting bushing and .005 inch space between the face of the bushing and that of the universal joint. The driving gears should never be meshed closer than .002 inch as tighter than this makes a grinding noise and there should never be more than .010 inch as there is apt to be a rattling noise if gears are too loosely fitted. Axle and drive shaft roller bearings can have from 1/16″ to ⅛″ end motion and about .005 inch up and down play.

There should be from .002 inch to .004 inch clearance between hub bearing on gear and hole in differential case to allow penetration of lubricant. There can be anywhere from .001 inch to .010 inch play between axle gears and spider pinions. An end play of 1/32″ between ends of

axle shafts is all right. The thrust plates on all models of cars later than 1917 should be .085 inch to .087 inch thick. Worn plates make it impossible to adjust driving gears properly. Excessive play between pinion and ring gear may be remedied sometimes by putting a new bushing in the drive shaft housing. This is a babbit bushing 1¾″ long and 1″ bore.

In overhauling the transmission be sure there is no more than .005 inch play between triple gear bushings and pins. When new bushings are used the flanged face should not project more than .007 inch from face of gear. Sleeve bushings should have not more than .005 inch play or less than .002 inch clearance. See that all transmission drums are free and that brake drum does not have more than 1/32″ end play. When the clutch has been adjusted properly a space of 13/16″ should be left between front side of clutch actuator or shift collar and drive plate. The clutch spring will be 2″ long if adjustment is correctly made.

With the Ford magneto the primary current varies from 6 to 24 volts. It is an alternating current generator and at a motor speed of 1,000 r.p.m. it reverses 1,600 times per minute or over 260 times per second. This current cannot be used to charge a storage battery but will operate lights very satisfactorily. To test the Ford magneto an alternating current volt meter is connected to magneto terminal and the ground and should show about 8 volts when engine is running throttled down.

Starting the Ford Engine in Cold Weather.—The instructions given by the Ford Motor Company for starting the engine in cold weather take into account the lower volatility of present day motor fuels. As gasoline does not vaporize readily in cold weather it is naturally

more difficult to start the motor under such conditions. The usual method of starting the engine when cold is to turn the carburetor dash adjustment one-quarter turn to the left in order to allow a richer mixture of gasoline to be drawn into the cylinders; then hold out the priming rod, while you turn the crank from six to eight one-quarter turns in quick succession, or turn the motor over a few times with the starter. Another method of starting a troublesome cold engine is as follows: Before you turn on the switch, (1) close throttle lever; (2) hold out priming rod while you give crank several quick turns, or turn the motor over a few times with the starter, then let go of priming rod (being careful that it goes back all the way); (3) place spark lever in about third notch and advance throttle lever several notches; (4) turn on switch; (5) give crank one or two turns, or close the starting switch, and the motor should start. After starting the motor it is advisable to advance the spark eight or ten notches on the quadrant and let the motor run until thoroughly heated up. If you start out with a cold motor you will not have much power and are liable to "stall." The advantage of turning on the switch last, or after priming, is that when you throw on the switch and start the motor, you have plenty of gas in the cylinders to keep the motor running, thereby eliminating the trouble of the motor starting and stopping. After motor is warmed up turn carburetor adjustment back one-quarter turn or to the point where motor runs best.

To facilitate starting many drivers make a practice of stopping their engine by pulling out on the priming rod, which has the effect of shutting off the air suction and filling the cylinders full of a very rich gasoline vapor. This should not be done unless the car is going to stand

over night or long enough to cool off. If the motor is stopped in this way and then started when hot, starting is apt to be difficult on account of the surplus gasoline in the carburetor.

When Oil Is Too Stiff.—When the Ford car or truck has been standing outside exposed to extreme cold weather, and especially if oil is used in the transmission that is too heavy, the speed and brake bands may drag, which makes the engine hard to crank by hand or if the starting battery is weak. The best way to prevent the car from moving forward, even if the hand lever is set in neutral, is to block the front wheels, both front and rear, to prevent car movement, and then jack up one of the rear wheels from the ground. As soon as the engine has warmed up, which it will do after a few minutes' running, leave the front wheel blocked and let down the jack. Even if the wheel is spinning, it will stop when the weight of the car rests upon it. More trouble of this nature is experienced with the worm drive truck than with the passenger cars because the lower drive reduction of the worm gears intensify the slight drag of the clutch drum bands or discs of the high speed clutch. Of course, this drag is sometimes due to tight bands or failure of the clutch throwout set screw to release the clutch fully when the hand lever is in neutral position. The remedy in this case is to adjust the set screw or brake bands properly. The Ford transmission when used in cold weather requires a lighter oil than it does in summer, but as several oil companies are supplying special oils for this purpose, the Ford owner has only to substitute the heavy lubricant with one of proper fluidity to overcome such trouble.

The Ford Cooling System in Winter.—The Ford radiator

core is apt to be seriously damaged during cold weather by the freezing of the cooling liquid. While the Ford radiators were made integral with outer shell for some time, as illustrated in Figs. 6 and 25, all later models of Ford cars have a separate stamping of steel, called the shell, which is removable from the radiator core and used as a finish as well as a protection for it, as shown at Fig. 154. Of course, in event of trouble, only the core needs repairing, as the shell will not be injured if the radiator freezes. Not only the radiator will suffer, but serious damage is apt to result to the cylinder block, which may be cracked beyond repair. An anti-freezing solution should be used in the circulation system during cold weather. Denatured alcohol and water can be used to good advantage and the radiator may be provided with a "winter front" of metal or a padded quilt arrangement to retain the heat once the engine has warmed the water or solution, as the case might be. The following table gives the freezing points of solutions containing various percentages of alcohol. It is best to be safe and use a strong enough solution, taking into account the lowest temperature that may be expected, this of course varying with locality.

A solution containing 20% alcohol, 80% water freezes at 15 degrees above zero Fahrenheit scale.

A solution containing 30% alcohol, 70% water freezes at 8 degrees below zero Fahrenheit scale.

A 50% or half and half solution will freeze at 34 degrees below zero Fahrenheit scale.

A solution composed of 60% water, 10% glycerine and 30% alcohol is more stable than a simple alcohol-water mixture and will freeze at about 8 degrees below zero Fahrenheit.

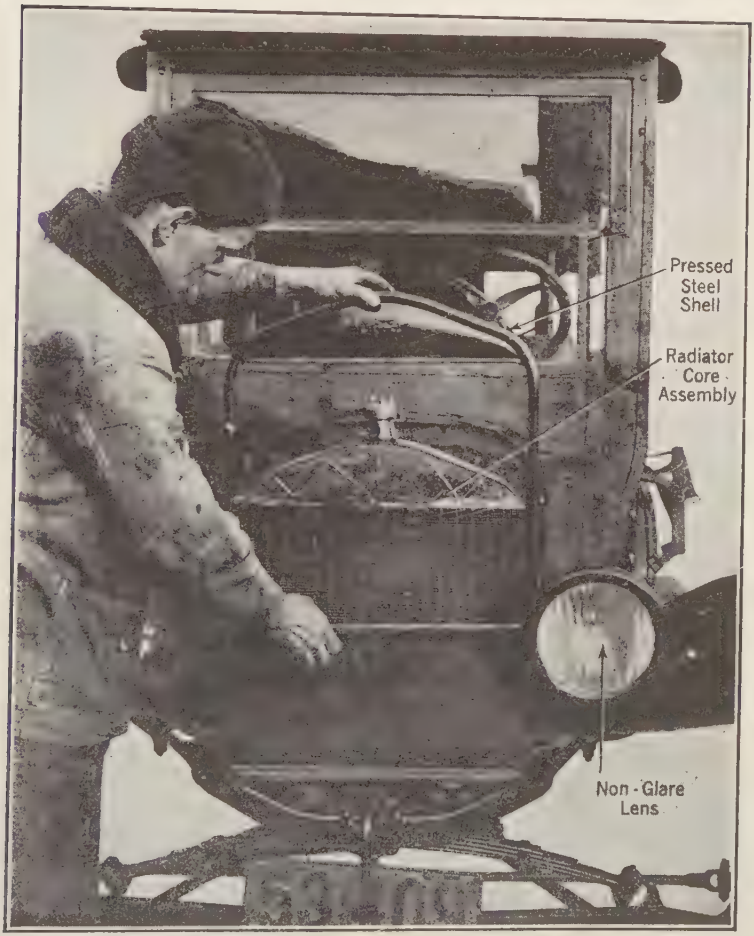


Fig. 154.—View of Ford Radiator Showing Removal of Shell From Core.

On account of boiling away and evaporation, fresh alcohol must be added frequently to maintain the strength of the mixture as the alcohol content will evaporate faster than the water.

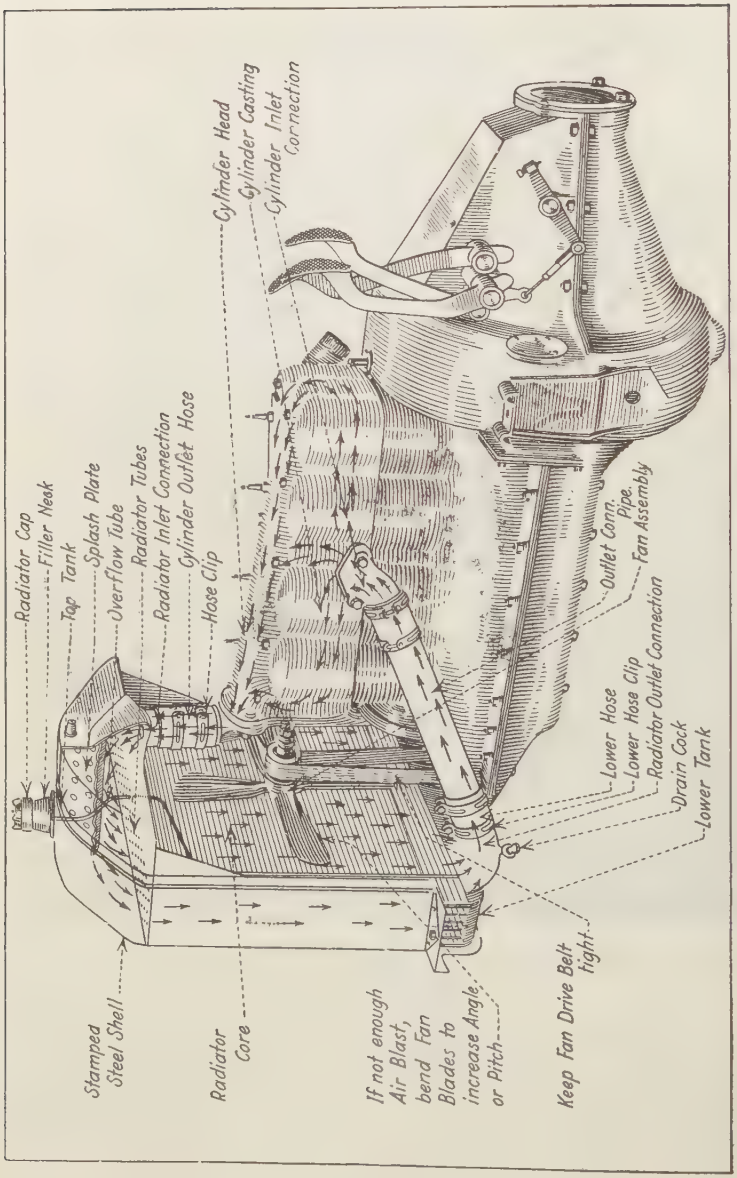


Fig. 155.—Ford Cooling System Showing Radiator Construction.

A small leak in a radiator may be repaired temporarily with brown soap, white lead or chewing gum, but a permanent repair by soldering should be made as soon as conditions permit. The complete Ford Model T cooling system is shown at Fig. 155.

Carburetor of Ford 1924-1925 Models and Its Adjustment.—The carburetor is an automatic float feed type having

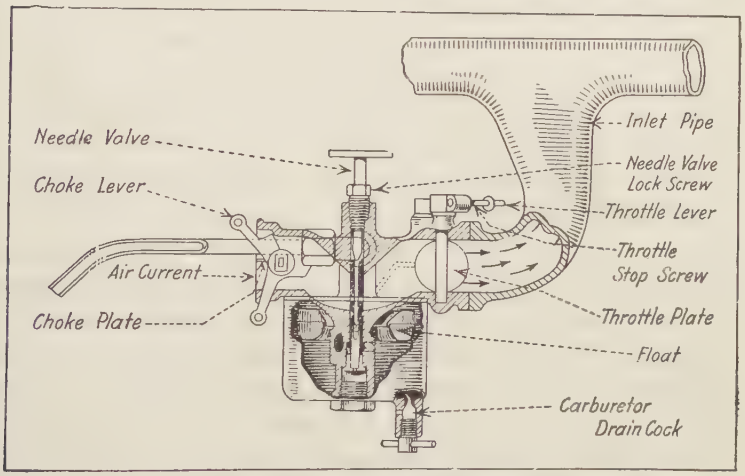


Fig. 156.—Carburetor Used on Late Models of Ford Cars.

but a single adjustment by gasoline regulating needle valve. The cross sectional view of the carburetor at Fig. 156 shows how the fuel enters the carburetor. The fuel is mixed with the entering air stream and passes through the inlet pipe of the engine in the form of an explosive mixture. When actually installed, a hot air pipe, not shown in illustration of carburetor but clearly outlined in Fig. 165, takes heated air from around the exhaust manifold. Warming the air facilitates vaporization of the gasoline. The gasoline, entering the bowl

of the carburetor, gradually raises the float to a point where the inlet needle is forced upwards into its seat, thus cutting off the flow of gasoline. As the gasoline in the bowl recedes, the float lowers, allowing the needle to drop from its seat and the flow of gasoline is resumed. It is plain to see that a constant level of gasoline is maintained in the carburetor by the automatic action of float and needle. The quantity of gasoline entering into the mixture is governed by the needle valve. The volume of gas mixture entering the intake pipe is controlled by opening and closing the throttle, according to the speed desired by the driver.

After the new car has become thoroughly worked in, the driver should observe the angle of the carburetor adjusting rod at which the engine runs most satisfactorily. In cold weather it will probably be found necessary to turn the dash adjustment one-quarter turn to the left, particularly in starting a cold engine. As gasoline vaporizes readily in warm weather, the driver will find it economical to reduce the quantity of gasoline in the mixture by turning the carburetor adjustment to the right as far as possible without reducing speed. This is particularly true when taking long drives where conditions permit a fair rate of speed being maintained and account for the excellent gasoline mileage obtained by good drivers.

A lean mixture has too much air and not enough gasoline. A rich mixture has too much gasoline and not enough air. A rich mixture will not only quickly cover the cylinders, pistons and valves with carbon, but will tend to overheat the cylinders and is likewise wasteful of the fuel. It will often choke the engine and cause misfiring at slow speeds, although at high speeds the

machine will run perfectly. The mixture should be kept as lean as possible without the sacrifice of any of the power of the motor. A lean mixture will often result in backfiring through the carburetor, for the reason that the gas burns slowly in the cylinder and is still burning when the inlet valve opens again, which causes the gas in the intake to ignite. A rich mixture is shown by heavy, black exhaust smoke with a disagreeable smell. Proper mixture will cause very little smoke or odor.

The usual method of regulating the carburetor is to start the motor, advancing the throttle lever to about the sixth notch, with the spark retarded to about the fourth notch. The flow of gasoline should now be cut off by screwing the needle valve down to the right until the engine begins to misfire, then gradually increase the gasoline feed by opening the needle valve until the motor picks up and reaches its highest speed and no trace of black smoke comes from the exhaust. Whenever it is necessary to turn the adjusting needle down more than a quarter turn below its normal position, the lock nut on top of the carburetor at the point through which needle passes should first be loosened, as otherwise it is impossible to tell when the needle is turned down in its seat too far. Turning the needle down too tightly will result in its becoming grooved and the seat enlarged. When these parts are damaged it is difficult to maintain proper adjustment of the carburetor. Having determined the point where the motor runs at its maximum speed, the needle valve lock nut should be tightened to prevent the adjustment being disturbed. For average running, a lean mixture will give better results than a rich one.

Late Ford Ignition System.—The Ford ignition system is unchanged in essentials and is practically the same

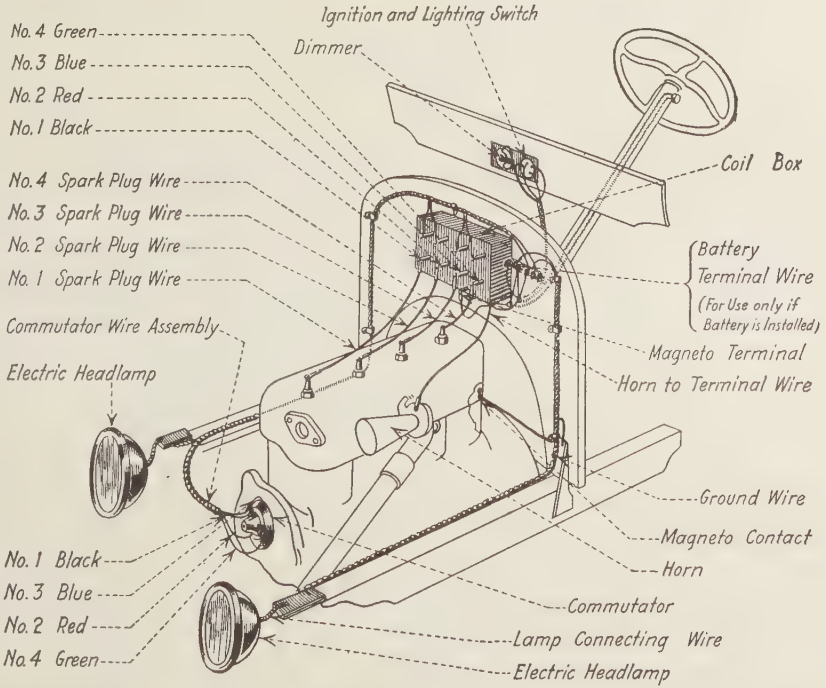


Fig. 157.—Ignition System of Late Models Ford T Cars.

as has been used for some years past, but the wiring has been changed slightly owing to the placing of the ignition and lighting switch on the cowl board. The wiring can be easily traced by inspecting the diagram given at Fig. 157. The present style of coil unit is properly adjusted when it leaves the factory and this adjustment should not be disturbed unless to install new points or to reduce the gap between the points which may have increased from wear. When adjustments are necessary they should, whenever possible, be made by one of the Ford service stations, who have special equipment for testing and adjusting units and will gladly furnish expert service. If the points are pitted they should be filed flat with a fine double-faced file and the adjusting thumb nut turned down so that with the spring held down the gap between the points will be a trifle less than 1/32 of an inch. Then set the lock nut so that the adjustment can not be disturbed. Do not bend or hammer on the vibrators, as this would affect the operation of the cushion spring of the vibrator bridge and reduce the efficiency of the unit. With the vibrators properly adjusted, if any particular cylinder fails or seems to develop only a weak action, change the position of the unit to determine if the fault is actually in the unit. The first symptom of a defective unit is the buzzing of the vibrator with no spark at the plug. Remember that a loose wire connection, faulty spark plug, or worn commutator may cause irregularity in the running of the motor. These are points that should be considered before laying the blame on the coil.

Should the insulation of the primary wires (running from coil to commutator) become worn to such an extent that the copper wire is exposed, the current will

leak out (*i. e.,* short circuit) whenever contact with the engine pan or other metal parts is made. A steady buzzing of one of the coil units will indicate a "short" in the wiring. When driving the car the engine will suddenly lag and pound on account of the premature explosion. Be careful not to crank the engine downward against compression when the car is in this condition, as the "short" is apt to cause a vigorous "back kick."

When the vibrators are not properly adjusted more current is required to make and break the contact between the points, and, as a result, at cranking speeds you would not get a spark between the spark plug points. Do not allow the contact points to become "ragged," otherwise they are apt to stick and cause unnecessary difficulty in starting, and when running they are apt to produce an occasional "miss" in the engine. It is a well known fact that in cold weather even the best grades of lubricating oil are apt to congeal to some extent. If this occurs in the commutator it is very apt to prevent the roller from making perfect contact with the contact points imbedded in the fibre. This, of course, makes difficult starting, as the roller arm spring is not stiff enough to brush away the film of oil which naturally forms over the contact points. To overcome this, as well as any liability of the contact points to rust, we recommend a mixture of kerosene with commutator lubricating oil, which will thin it sufficiently to prevent congealing, or freezing, as it is commonly called. You have probably noticed in starting your car in cold weather that perhaps only one or two cylinders will fire for the first minute or so, which indicates that the timer is in the condition described above and as a

consequence a perfect contact is not being made on each of the four terminals.

Ford Model T Starting and Lighting System.—The wiring diagram shown at Fig. 158 shows the starting and lighting system of late model Ford T cars. It is simpler than the F. A. System described in this book and applied to earlier models. If this is studied in connection with the diagram shown in Fig. 157 and views of motor at Figs. 164 and 165 no difficulty will be experienced in tracing the various wires and cables. The charging rate of generator is set so as to cut in at engine speeds corresponding to 10 miles per hour in high speed and reaches a maximum charging rate at 20 miles per hour. At higher speeds the charge will taper off, which is a settled characteristic of a generator. This operation of cutting in and cutting out at suitable speeds is accomplished by the cut-out, which is mounted on the generator. This cut-out is set properly at the factory and should not under any circumstances be tampered with.

The ammeter is located on the instrument board as shown at Fig. 163. This indicator registers "charge" when the generator is charging the battery and "discharge" when the lights are burning and the engine not running above 10 miles per hour. At an engine speed of 15 miles per hour or more the ammeter should show a reading of from 10 to 12. If the engine is running above 15 miles per hour and the ammeter does not show a proper reading, first inspect the terminal posts on the ammeter, making sure that the connections are tight, then disconnect the wire from the terminal on generator, and with the engine running at a moderate speed, take a pair of pliers or a screw-driver and short-

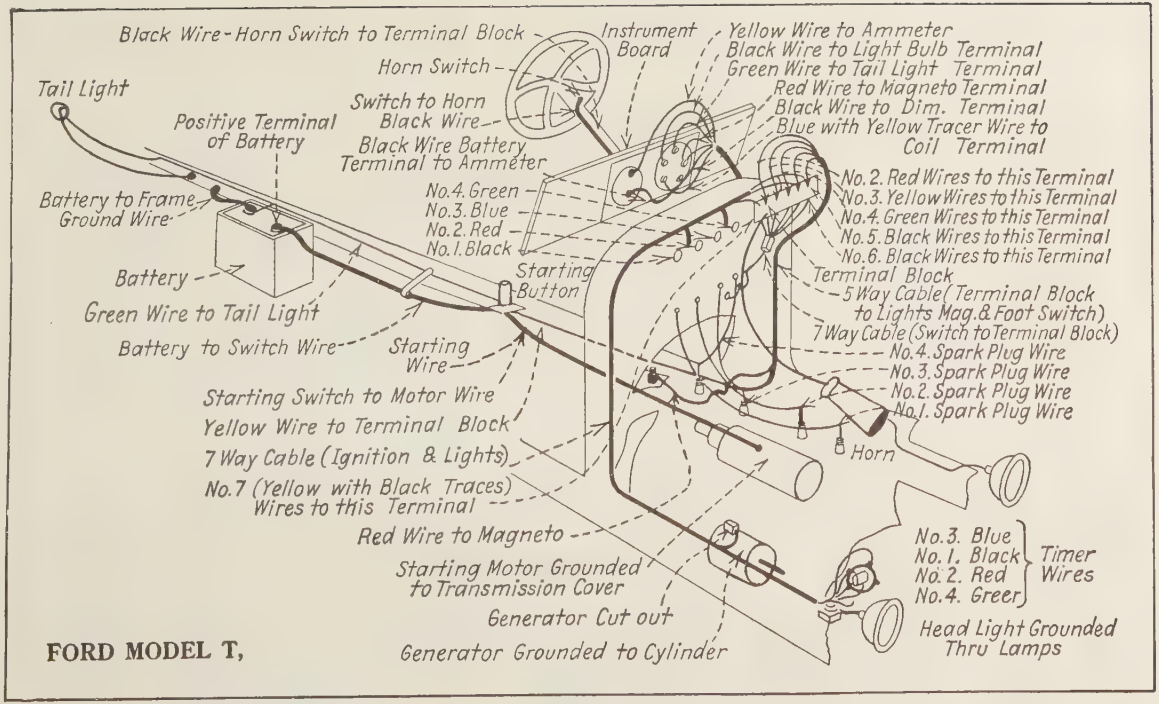

Black Wire - Horn Switch to Terminal Block
Instrument Board
Yellow Wire to Ammeter
Black Wire to Light Bulb Terminal
Green Wire to Tail Light Terminal
Red Wire to Magneto Terminal
Black Wire to Dim. Terminal
Blue with Yellow Tracer Wire to Coil Terminal
Horn Switch
Switch to Horn Black Wire
Black Wire Battery Terminal to Ammeter
Tail Light
Positive Terminal of Battery
Battery to Frame Ground Wire
No. 4. Green
No. 3. Blue
No. 2. Red
No. 1. Black
No. 2. Red Wires to this Terminal
No. 3. Yellow Wires to this Terminal
No. 4. Green Wires to this Terminal
No. 5. Black Wires to this Terminal
No. 6. Black Wires to this Terminal
Terminal Block
5 Way Cable (Terminal Block to Lights Mag. & Foot Switch)
7 Way Cable (Switch to Terminal Block)
Starting Button
Battery
Green Wire to Tail Light
Battery to Switch Wire
Starting Wire
No. 4. Spark Plug Wire
No. 3. Spark Plug Wire
No. 2. Spark Plug Wire
No. 1. Spark Plug Wire
Starting Switch to Motor Wire
Yellow Wire to Terminal Block
7 Way Cable (Ignition & Lights)
Horn
No. 7 (Yellow with Black Traces) Wires to this Terminal
Red Wire to Magneto
No. 3. Blue
No. 1. Black
No. 2. Red
No. 4. Green
Timer Wires
Starting Motor Grounded to Transmission Cover
Generator Cut out
Head Light Grounded Thru Lamps
FORD MODEL T,
Generator Grounded to Cylinder

Fig. 158.—Ford Model T Starting, Lighting and Ignition System Showing All Wiring and Relation of Units.

circuit the terminal stud on the generator to the generator housing. If the generator is O. K. a good live spark will be noted. (Do not run the engine any longer than is necessary with the terminal wire disconnected.) Next inspect the wiring from the generator through the ammeter to the battery for a break in the insulation

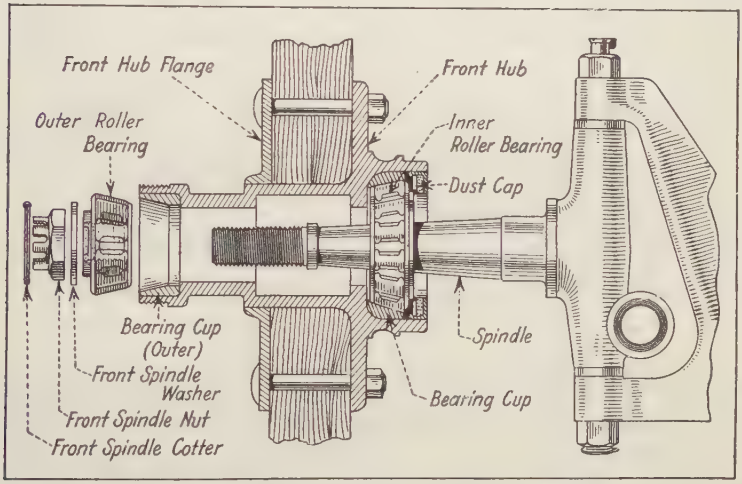


Fig. 159.—Sectional View of Ford Model T Front Wheel Hub Showing Taper Roller Bearings.

that would result in a short-circuit. If the trouble is not located, then remove the dust cap from the end of generator and thoroughly clean the generator commutator, using for this work a fine grade of sandpaper which has been slightly oiled. With the motor running, hold the sandpaper against the commutator with the fingers until all dirt has been removed and a bright surface attained.

The lighting system consists of two headlights and a tail light operated by a combination lighting and ignition switch located on the instrument board. The head-

lamp bulbs are of 6-8 volt, double filament gas filled type. The major filament is 21 candle-power, and the minor filament is 1¾ candle-power. The small bulb used in the tail light is of 6-8 volt, single contact, two candle-power type. All of the lamps are connected in parallel so that the burning out or removal of any one of them will not affect the other. Current for the lamps is supplied by the battery. Do not connect the lights to the magneto as it will result in burning out the bulbs and might discharge the magnets. Special bulbs, intended to be wired in series, are necessary if the magneto is used for lighting, as is the case on cars not provided with electric starting and lighting system.

When the car is delivered to the owner the headlamps are properly focused and aligned, and they should require no attention other than replacement of burned out bulbs or broken lenses, and re-focusing or re-aligning should they get out of focus or alignment. Headlights equipped with the Ford refracting lens and Ford 21 candle-power gas filled bulbs when properly focused and aligned pass the lighting requirements of all states.

To Focus Headlights.—Place the empty car on a level surface facing a white wall or screen 25 feet in front of the headlights. See Figs. 160 and 161. This wall must be shielded from direct light sufficiently so that the light spots from the headlights can be clearly seen and should be marked off with black lines as follows. One horizontal line 32 inches above the surface on which the car is standing and three vertical lines 14 inches apart. The center line of the car should be directly in front of the center vertical line. Turn on the bright lights, then focus by means of the screw on the

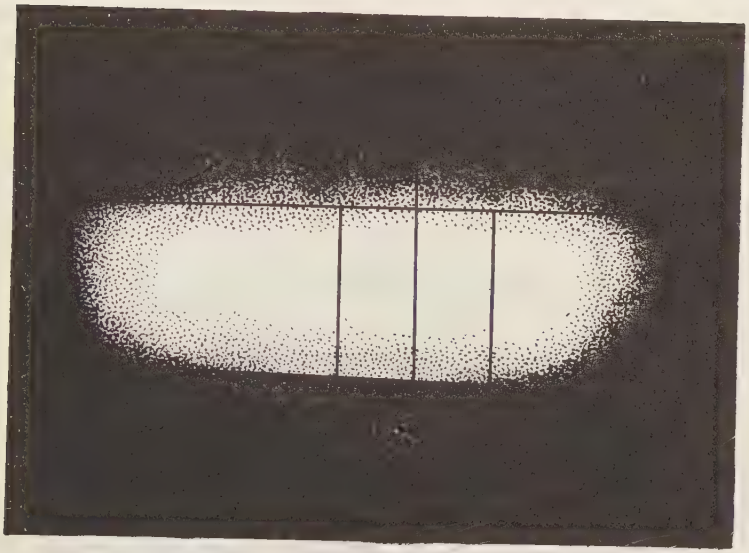


Fig. 160.—Left Headlamp Properly Focused and Aligned.

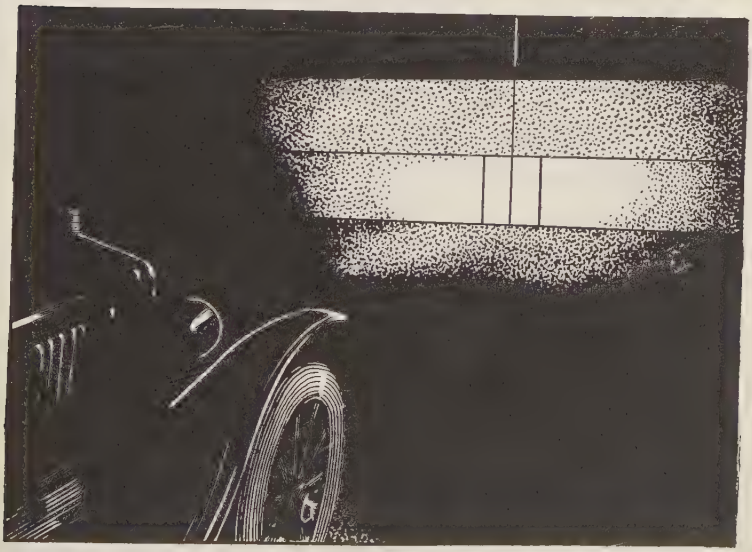


Fig. 161.—Both Headlamps Properly Focused and Aligned.

back of the lamp, adjusting to obtain an elongated elliptical spot of light on the wall with its long axis horizontal. Adjust the bulb to obtain as good contrast and as well defined cut-off across the top of the spot of light

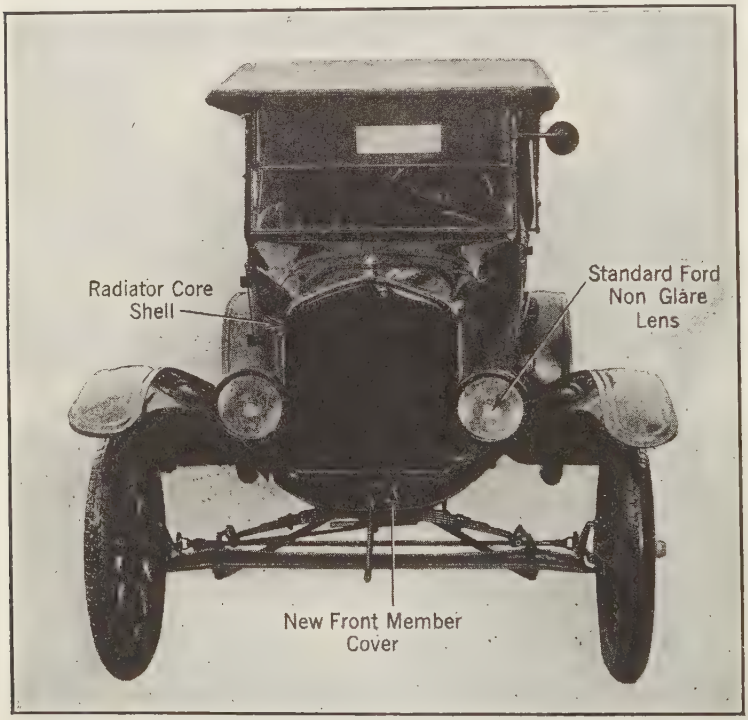


Fig. 162.—Front View of Latest Model Ford Touring Car Showing Apron at Lower Part of Radiator, also Placing of Headlamps.

as possible. With the lights thus focused for the "bright" filament, the "dim" will be satisfactory.

Headlamps may be aligned by bending the headlamp brackets so that the tops of the bright spot on the wall or screen 25 feet in front of the car are at a line 32

inches above the level surface on which the car stands and so that the beam of light from each headlamp extends straight forward; that is, with the centers of the elliptical spots of light 28 inches apart. Owners may prefer to have their lamps focused and aligned by an authorized Ford dealer, as all Ford dealers are specially equipped to do this work.

Roller Bearing Front Wheels.—Several million Ford cars are on the roads equipped with ball bearing front wheel hubs as shown at Fig. 32, but those bearings did not always prove satisfactory on account of their small size when used on the trucks or delivery cars. The roller bearings can be placed in hubs formerly equipped with ball bearings when these wear if the work is too severe for the cups, cones and balls. The taper roller bearing installation is shown at Fig. 159, and as will be apparent, there is considerably more bearing area along the length of the rollers and races than the almost minute point support obtained with balls. To remove front wheels, first take off hub cap, remove cotter pin and unscrew castle nut and spindle washer. The adjustable bearing cone can then be taken out and the wheel removed. Care should be taken to see that the cones and lock nuts are replaced on the same spindle from which they were removed, otherwise there is a liability of stripping the threads, which are left on the left spindle and right on the opposite as you stand facing the car.

The wheels should be jacked up periodically and tested, not only for smoothness of running, but for side play as well. If in spinning a front wheel a sharp click occurs now and then and the wheel is momentarily checked, it is probable that there is a chipped or split

ball in the bearing, which should be removed, otherwise it may necessitate the removal of the entire bearing. A wheel in perfect adjustment should, after spinning,

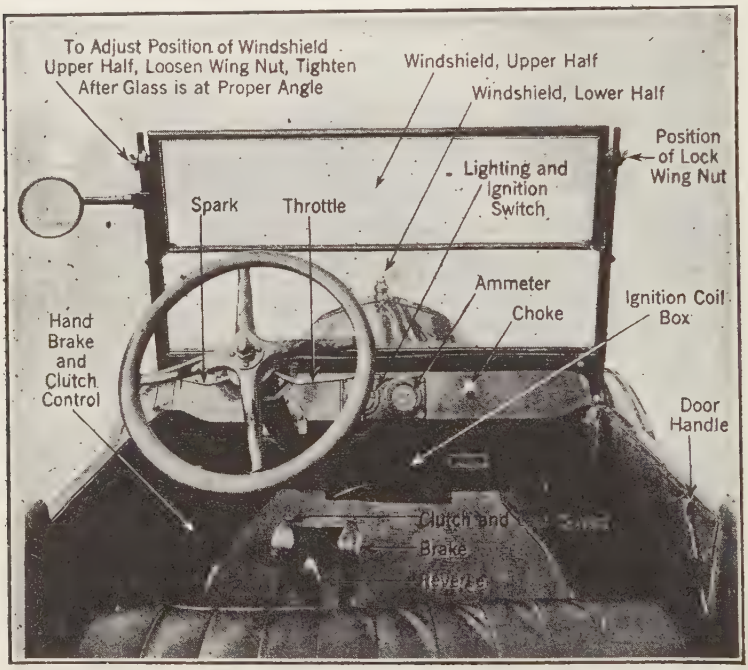


Fig. 163.—Front Compartment of Latest Ford T Car Showing Switch, Ammeter and Primer on Cowl Board, also New Windshield Design and Control Levers and Pedals.

come to rest with the tire valve directly below the hub. Undue wear of the hub bearings is usually caused by lack of lubrication and excessive friction, due to the adjusting cone being screwed up too tight. It is a good plan to clean the bearings frequently and keep the hub well filled with grease.

Whenever it is necessary to install roller bearing

cups, either in changing over from ball bearings to roller bearings or in replacing worn cups, the work should be done by a Dealer or Garage which has the necessary equipment for this work. In order to avoid excessive wear of the bearings it is essential that the cups be fitted absolutely true, and this is practically impossible without the use of special equipment.

First pack the hub full of clean good quality cup grease. Take the inner cone with its rollers and pack it with grease, filling all of the space around and between the rollers. Then place the inner cone in the larger cup. Next, drive the dust ring with felt washer into the inner end of the hub so that it is flush with the end of the hub. Place the wheel carrying the inner bearings with dust ring on the spindle. The inner cone is a one-thousandth fit, or, in other words, a slip fit on the spindle. It is never necessary to force the cone onto the spindle as the cups are forced into the hub. Pack the outer or threaded cone and rollers with cup grease, filling all the space between the rollers as was done with the inner cone. The cones are made up in right and left-hand threads to correspond to the threads on the spindles. Care should be taken that a right-hand threaded cone is not forced onto a left-hand threaded spindle. The right-hand thread is on the left-hand side of the car, while the left-hand thread is on the right-hand side of the car. Place the cone on the spindle, running it up tight enough so that the wheel seems to bind; give the wheel a few turns to be sure that all the working parts are in perfect contact; then back off the cone ¼ to ½ a turn, which will be sufficient to allow the wheel to revolve freely without end play. To determine if there is end play, grasp the spokes and shake the

wheel. Do not mistake loose spindle bushings for loose bearings. Insert a cold chisel between axle and spindle to take up any play while testing the bearings. Next

Fig. 164.—View of Engine Compartment, Left Side of Motor Showing Horn Placing, Ignition Wiring and Junction Block on Dash for Wires, also Starting Motor Placing.

put on the spindle washer and nut, drawing the nut to a firm bearing. Make sure that the cone has not been forced out of adjustment. This can be determined by

giving the wheel a few turns. Insert the cotter pin which locks the nut on the spindle, fill the hub cap with grease and screw it in place on the hub.

Ford Model T Engine Changes.—The illustrations at Figs. 164 and 165 of the engine compartment of the

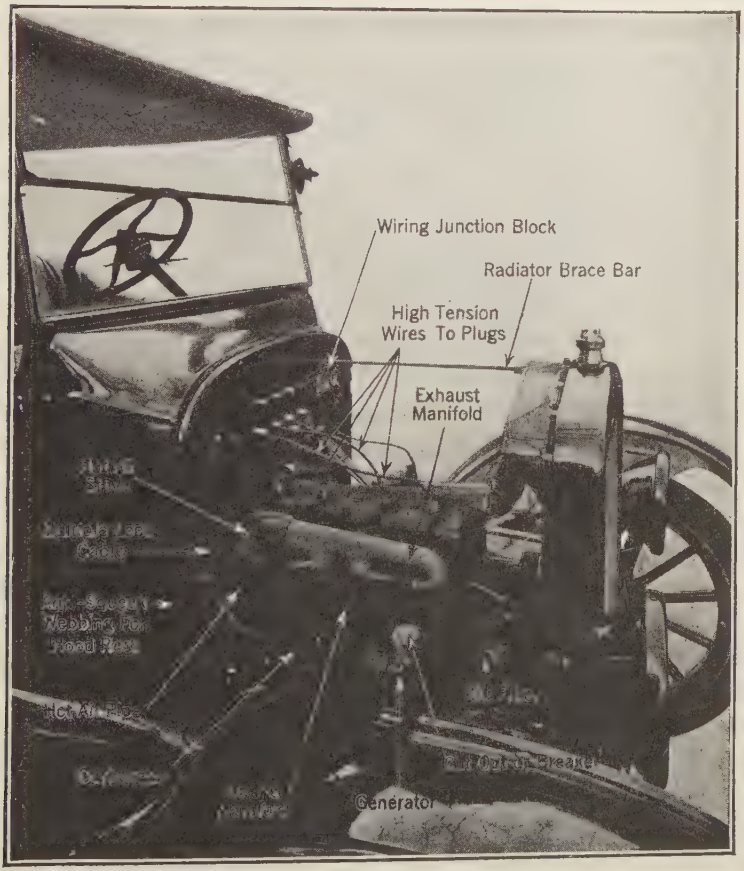


Fig. 165.—View of Engine Compartment, Right Side of Motor Showing Carburetor, Inlet and Exhaust Manifolds, Generator and Cut-out, Spark Plugs and Ignition Wiring.

latest Model T power plant do not disclose any radical changes from the engines illustrated in other parts of this book. Such changes as have been made are merely of details and do not show in the photographs. For example, the oil feed pipe inside the motor has had a small funnel at the supply end to catch oil splashed up by the revolving flywheel. The new motors utilize a pipe having an oval mouth instead of round mouth funnel so the oil pipe will receive more of the splash and more oil be fed to the splash troughs. Another change that will be appreciated by repairmen is a change in the bottom plate that makes number 4 rod and rear main bearing more accessible for inspection and adjustment. Some of the latest motors are coming through with special light pistons which are somewhat lighter than those formerly supplied and which reduce engine vibration. These pistons can be used with older model Ford motors but special wrist pins are required. As the view at Fig. 164 shows, the signal horn is attached to one of the cylinder head bolts. The accessible location of the generator and the current cut-out is clearly shown. Attention is also directed to the junction box for lighting system wiring.

New Fordson Tractor Changes in Detail.—In the following notes furnished by the Ford Company are described the improvements which have been made in the Fordson tractor in recent years. The engine of the Fordson tractor as it leaves the factory is not provided with a speed governor, but such governors have been placed on the market by various concerns, and the Ford firm, therefore, provides a small flange on the forward end of the mixer chamber for mounting a governor. Instructions have been issued to service men for mounting the governor, and it is recommended that the latter be adjusted to keep

the engine running at about 1,000 r.p.m. The throttle lever on the steering column can still be used to reduce or increase the speed by moving it against the force of the governor.

An improvement has been made in the worm gear rear axle drive whereby that drive is considerably strengthened. The present steel worm has three instead of two leads as on the earlier models, and the wheel 51 teeth instead of 35. The elimination of the so-called hunting tooth in the wheel is claimed to have resulted in the teeth on the wheel wearing more uniformly smooth. The worm itself has been increased in diameter and thereby strengthened, and it is figured that the tooth pressure has been lowered 27 per cent. The driving splines on the worm shaft have been increased in depth by 75 per cent., greatly augmenting their driving power.

Originally the Fordson tractor was put out without fenders by the company, but a design of fender for the rear wheels has been developed and these fenders are now furnished with the tractor at a slight increase in price. The equipment offered comprises, in addition to the fenders, a platform for the driver to stand on and a tool and spare part box and the tractor so equipped is shown at Figure 166. The advantages claimed for this equipment are as follows: It minimizes the possibility of mud and dust being thrown by the tractor wheels on the driver and the engine; protects the driver from injury by the wheels and cleats; provides a convenient receptacle for tools, spare parts, etc.; prevents the tractor from sinking into mud, sand or soft ground beyond a certain depth; provides a platform of considerable size, which is a convenience to the driver in getting on and off the tractor; offers him an opportunity to stand up and rest

by changing his position at intervals without getting off the tractor, and provides a carrying space for grain or chains or helpers.

Chromium-silicon alloy steel valves are now used in the engine. Valves of this heat-resisting material, with its high resistance to pitting and warping, are particu-

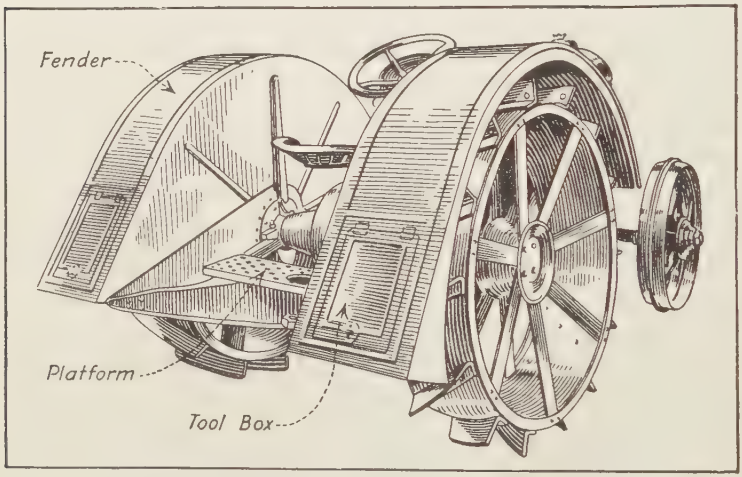


Fig. 166.—Fordson Tractor Equipped With Mud Fenders and Platform for Operator.

larly desirable in a tractor engine, which, owing to the heavy duty service, operates at considerably higher temperatures than automobile engines. The valves are heat-treated, hardened and ground, with the result that wear at the end where the stem comes in contact with the tappet, and within the valve stem guide, is greatly reduced as compared with the type of carbon steel stem and cast iron head valve formerly used. This means longer valve life and less trouble with carburetion due to air leakage past the valve stems. Removal and installation of the

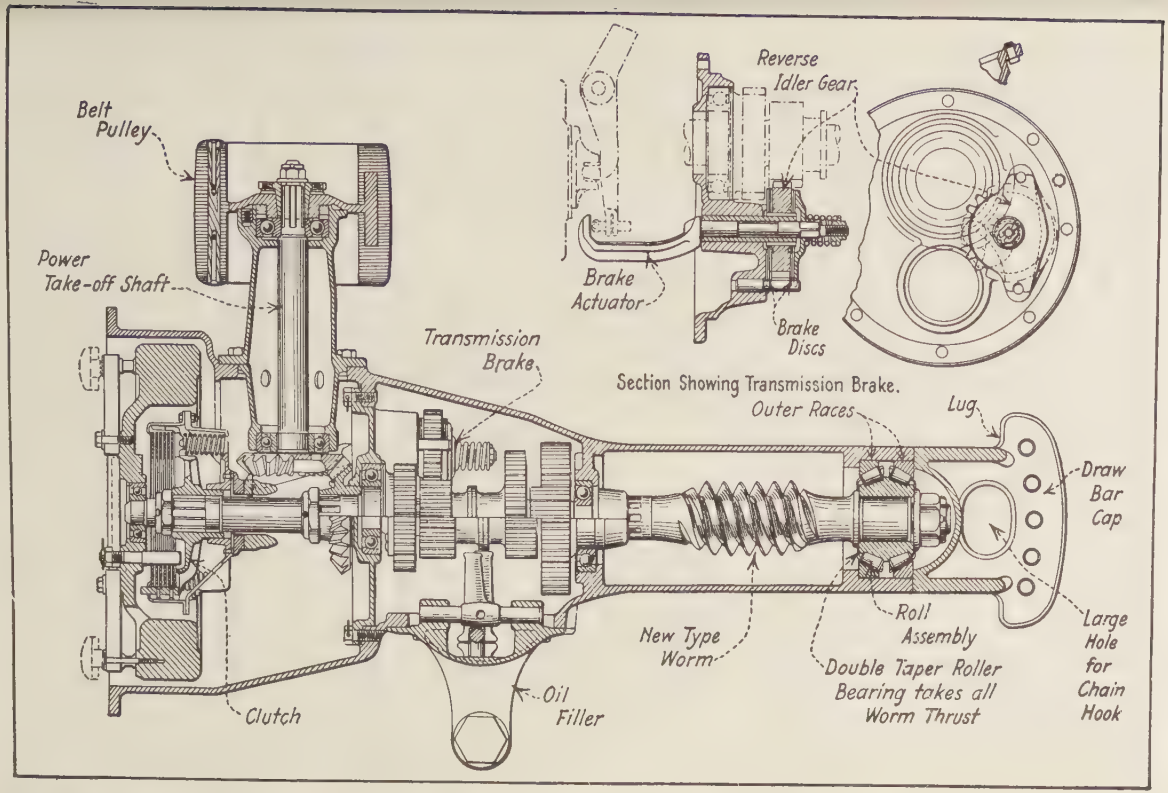


Fig. 167.—Horizontal Section of Fordson Tractor Transmission Showing New Worm Shaft, Taper Roller Bearings and New Transmission Brake Details.

valves is facilitated by the use of a split collar with the spring washer, instead of a pin, which is not as easy to handle.

In the original design of the tractor ball bearings were used on the worm shaft to take combined thrust and radial load, but these were later replaced by double Timken roller bearings of a special design as shown at Fig. 167. The two outer rings or cups are interchangeable and the cone or roller unit can be assembled on the worm with either end facing the rear. The taper roller bearings have greatly increased the carrying capacity of the worm.

The toe-in of the front wheels has been reduced. Many Fordson tractors are now shod with rubber tires for industrial service in factories and on roads, and with the larger toe-in there is no undue wear on the front tires. The wheels are now set so the front tires are ¼ inch closer together at the front than at the rear, making for easier steering, an important consideration in road work.

The width of the cams of the engine has been increased from ⅞ inch to 1⅛ inches to increase the wearing surface. A new dust-proof and water-proof coil box is now furnished with the tractor. Both the bottom and the back are made of reinforced heavy rubber, and tight joints are assured by the use of felt packings and cork gaskets between the cover and box. Improved hold-down springs are placed in the cover, these holding the coils tightly against the box contacts, thus insuring good electrical connections despite vibration inevitable when tractor is operated on rough ground. A trough is provided at the back of the coil box cover to prevent water from reaching the terminals at the back of the box. The new coil box is shown at A, Fig. 168.

New rear wheels of the same general type as the earlier ones are now used. These wheels have seven instead of six spokes and weigh 45 pounds more each. The hub is in the middle of the wheel instead of being offset

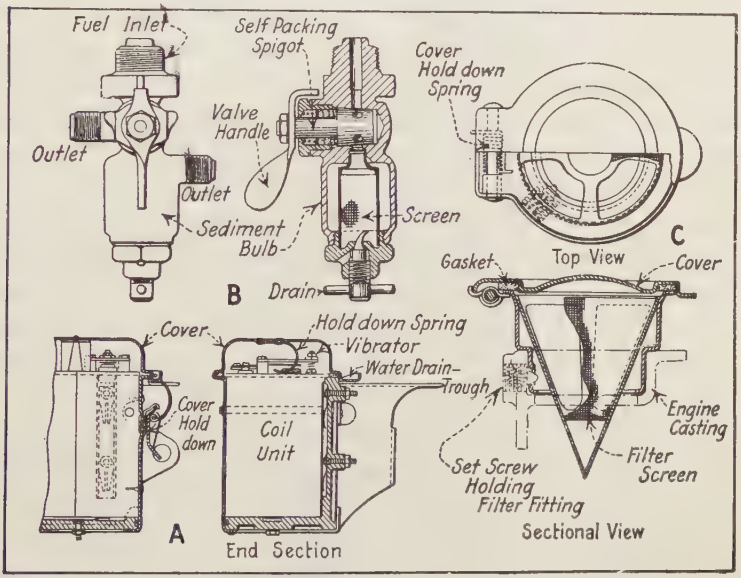


Fig. 168.—A—Latest Fordson Tractor Coil Box. B—Sediment Bulb and Two Way Shut-off Valve Details. C—New Pressed Steel Oil Filler Fitting.

to one side, which change has been made to equalize the load on the spokes. The cleats, which are riveted to the rim of the wheel, have holes in them for attaching grousers.

A sediment bulb is provided for the fuel tank and incorporates a two-way valve and a removable screen. The screen has a small nipple on the end to make it assemble easily, and it can be removed without disturbing

any of the connections. A leak-proof valve is used, provided with self-adjusting packing, and is located so it can be operated from the seat. Details of this sediment bulb are shown in the drawing at Fig. 168B.

A brake is now provided to make gear shifting easier. It is of the multiple disk type, is incorporated in the transmission plate and reverse idler gear sub-assembly, and is operated by the clutch pedal after the clutch has been disengaged. This brake can be applied whether the gears are in neutral or in any other position. Its construction and application are shown at Fig. 167.

The breather is now located in the dash, where it is better protected against dust than it was in its former location. A new design of oil filler is now used, as shown at Fig. 168C. This has a large screen, which allows the oil to flow in rapidly. The cover is self-closing, is held closed by a spring, and is dust-tight. This oil filler is made of sheet metal and the method of holding it in place in the engine casting is shown in the illustration. A large sediment chamber is now provided in the bottom pan of the crankcase. This is so located that the engine oil constantly passes across the entrance to it, so that any sediment will drop into it, from which it may be removed by taking out a large screw plug.

Most of the large castings, including the transmission housing, differential housing, drawbar cap and cylinder block, are now made of what the Ford Company refers to as its Grade A iron, which is really a semi-steel. A change has been made in the design of the drawbar cap, which is now provided with lugs and a large hole to permit of inserting a rope or the hook of a towing chain. Minor improvements include the adoption of a new style rubberized fan belt, which has longer life, improvements

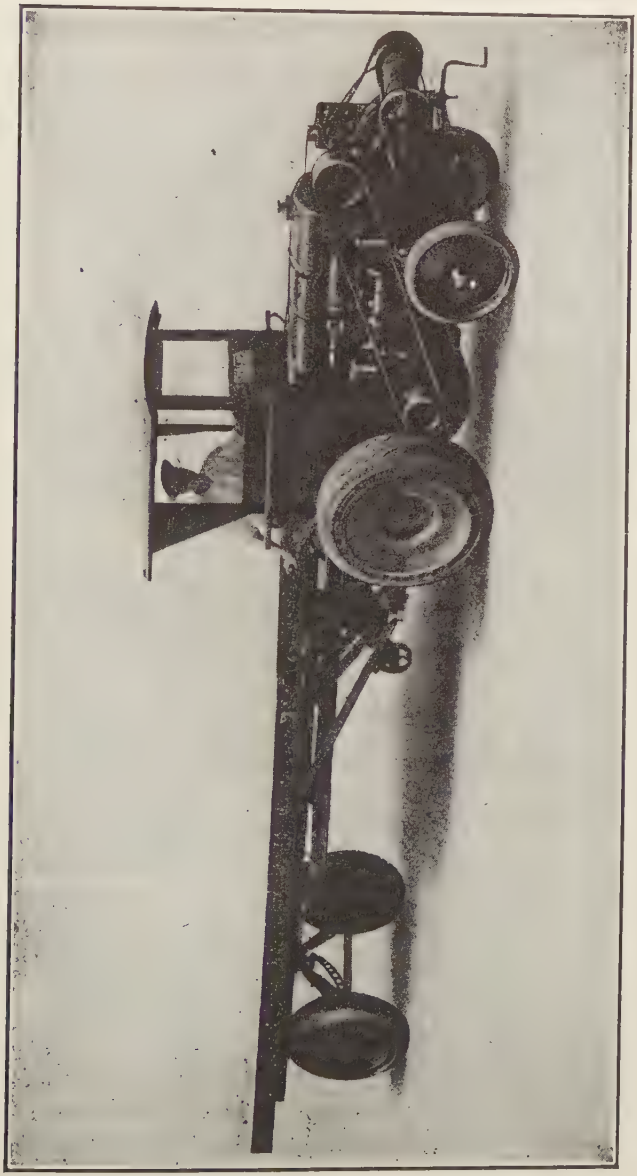


Fig. 169.—An Interesting Industrial Application of Fordson Tractor Hauling Trailer, Equipped With Cab and Solid Rubber Tires for Road Use.

in the heat treatment of various parts and heat treatment of the front axles.

An interesting industrial application of the Fordson tractor is shown at Fig. 169. This outlines its equipment with cab for the operator's protection and also with special dual solid rubber tire equipment on rear wheels and single solid tires on front wheel. It is used to haul a trailer specially made for use with it, and the winch attachment at the front end is useful in raising heavy weights or even in helping out the tractor if it becomes mired when the trailer is carrying a heavy load. The winch is operated by belt from power take-off pulley. The Fordson tractor can be used in many industrial applications as well as in agricultural work and space is not available in a treatise of this nature to even suggest the multitude of uses.

Schedule of Standard Repair Charges.—The practice of charging a flat rate for labor required in handling the various repair operations was established by the Ford Motor Company several years ago, after its practicability had been proven in factory branch service stations. The fact that this method of determining labor charges has since been adopted by automobile manufacturers generally is convincing proof that the flat rate system has proven satisfactory to the customer as well as the service station. These charges are predicated on the fact that service stations will use only authorized Ford parts and have adequate equipment of special tools to reduce labor to the minimum. The Ford owner cannot expect that these charges will be uniform under all conditions, but they can be taken as a guide to what can be expected if the work is done by competent mechanics familiar with the Ford car mechanism. Experience has

proven that the greatest point of dissatisfaction in handling service work is eliminated when the customer understands in advance exactly what the labor cost will amount to on a certain repair job. In all well organized service stations the repair order which the customer signs clearly specifies the labor cost of the work to be performed. This precludes the possibility of any misunderstanding or argument with a customer when a job is completed and the bill presented for payment. The customer is entitled to an estimate of the labor charges before the work is undertaken, and on the other hand the dealer must have the assurance that the labor bill will be paid when the work is finished. All parts are charged for at established prices in addition to the labor.

ENGINE DIVISION

The following charges cover work on cars driven into the service station:

Operation Number		Labor Charges
1.	Overhaul motor and transmission	$25.00
2.	Overhaul motor only	20.00
3.	Overhaul transmission only, or repair or replace magneto	14.00
4.	Rebraze crankcase arms or support or repair leak in case by taking out the motor	12.00
5.	Install or refit one piston or one connecting rod	4.50
6.	Install or refit two or more pistons or connecting rods	6.00
7.	Tighten one connecting rod bearing	2.50
8.	Tighten two or more connecting rod bearings	4.50
9A.	Replace transmission bands touring or runabout, $2.75 (with starter)	3.35
9B.	Replace transmission bands, sedan or coupe	4.35
10.	Replace transmission cover gasket, $2.50; closed car and with starter	3.00
11.	Change motor	6.50
12.	Replace camshaft, and refit bearings	5.00
13.	Replace cam gear—large	3.00

Operation Number		Labor Charges
14.	Replace cylinder front cover	3.00
15.	Grind valves and clear carbon	3.75
16.	Remove carbon only (this operation to be used only when customer will not permit grinding of valves)	1.75
17.	Repair cylinder head bolts stripped—one or two	3.00
18.	Repair cylinder head bolts stripped under dash	5.00
19.	Clean out oil feed pipe	3.25
20.	Replace cylinder head gasket	1.00
21.	Replace radiator or all three hose connections	.75
22.	Replace one hose connection only	.40
23.	Replace crankshaft starting pin, or pulley	1.50
24.	Tighten motor to frame	1.00
25.	Clean crankcase or install gasket under lower cover	.75
26.	Replace carburetor or manifold—or repair leak in manifold	.75
27.	Install new butterfly spring	.75
28.	Overhaul carburetor	1.50
29.	Repair leaky carburetor	1.00
30.	Replace commutator wire loom	.75
31.	Replace commutator case or brush	.50
32.	Replace commutator pull rod joint	.60
33.	Replace or rebush fan pulley assembly	.60
34.	Adjust clutch fingers and transmission bands	.60
35.	Adjust transmission bands only	.40
36.	Stop oil leak in valve doors	.50
37.	Install transmission band springs—each	.50
38.	Replace cylinder water jacket plug—one or more	.40
39.	Install new starting crank handle	.50
40.	Replace flywheel ring gear	12.00
	Operations 5 and 15 combined on one order	6.50
	Operations 6 and 15 combined on one order	8.00
	Operations 12 and 15 combined on one order	6.50
	Operations 15 and 17 combined on one order	4.50
	Operations 9 and 19 combined on one order	5.00
	Operations 10 and 19 combined on one order	3.50
	Operations 30 and 31 combined on one order	.75

No charge for operation 10 when combined with operation 9.

No charge for operation 16 when combined with operations 5, 6, or 12.

No charge for operation 21 when combined with operations 228 or 238.

Operation Number		Labor Charges
	No charge for operation 34 when combined with operation 9.	
	No charge for operation 21 when combined with operation 14.	
	Parts brought in or shipped in for repairs:	
55B.	Overhaul motor and transmission	20.00
56B.	Overhaul motor only	14.00
57B.	Overhaul transmission only	4.00
58B.	Rebore cylinder only	3.50
59B.	Rebore cylinder only, including fitting of pistons	4.50
60B.	Rebore and rebabbitt cylinder, including fitting of pistons	6.50
61B.	Rebabbitt cylinder only	2.50
62B.	Rebabbitt cylinder, fit crankshaft, and run-in	4.50
63B.	Rebore and rebabbitt cylinder, including fitting of pistons, crankshaft, connecting rods, and running-in	8.00
64B.	Rebore and rebabbitt cylinder, fit pistons, valves, push rods, camshaft, crankshaft, connecting rods and run-in	10.00
65B.	Rebore and fit pistons and valves	4.50
66B.	Rebore and fit pistons, valves, push rods, and straighten and fit camshaft	6.50
67B.	Fit pistons, crankshaft, and run-in (rebored block)	2.50
68B.	Rebush three transmission drums	1.50
69B.	Rebush transmission drums—each	.60
70B.	Rebush triple gear assemblies	1.50
71B.	Braze crankcase arms and supports	4.00
72B.	Repair crankcase drain plug housing	2.50
73B.	Overhaul and repair carburetor	1.00
74B.	Disassemble $\frac{5}{8}$", $\frac{9}{16}$" or $\frac{3}{4}$" magnets from flywheel and install new set	1.00
75B.	Straighten crankshaft	1.00
76B.	Straighten camshaft	.60
77B.	Straighten camshaft and fit bearings	1.00
	Operations 71B and 72B combined on one order	3.75

REAR SYSTEM DIVISION

The following charges cover work on cars driven into the service station:

Operation Number		Labor Charges
96.	Overhaul complete rear axle assembly	$7.00
97.	Replace rear axle assembly	2.50
98.	Replace rear axle shaft, drive shaft pinion, or drive gear (no other work necessary)	5.00
99.	Repair or replace drive shaft tube	4.00
100.	Repair or replace one rear radius rod	1.50
101.	Tighten rear radius rod	.60
102.	Straighten rear radius rod (in cars)	.60
103.	Install universal joint	3.00
104.	Straighten axle shaft (without removing from car)	1.50
105.	Tighten universal ball cap bolts	.75
106.	Install felt and steel washers—one side, 75c.; both sides	1.25
107.	Install brake shoes and equalize emergency brakes—one shoe, 75c.; both	1.25
108.	Tighten rear hub lock nut—one side, 40c.; both sides	.60
109.	Fit new hub keys—one side, 50c.; both sides	.75
110.	Install outer roller bearing—each	1.25
111.	Replace pull rod supports—one support, 40c.; both supports	.60
112.	Adjust pull rods or replace one	.60
113.	Replace or rebush hub brake cam—each side	1.50
	SPRINGS	
114.	Replace spring perches—one, 75c.; both	1.25
115.	Rebush spring and perches	1.75
116.	Install or tighten rear spring clips	.60
117.	Pad rear spring to line up body or replace rear spring tie bolt only	2.00
118.	Remove front and rear springs, polish and graphite leaves only—one, $2.50; both	4.50
119.	Replace rear spring tie bolt or new leaf, including polishing and graphiting of leaves, and lining up of body	3.00
	Operations 98 and 119 combined on one order	7.00
	Operations 98 and 117 combined on one order	6.00
	Operations 98 and 116 combined on one order	5.00
	Axle overhaul, when car has shock absorbers and owner will not permit removal—extra	1.00
	Axle overhaul, when car is equipped with special hub brakes—extra	1.50

Operation Number		Labor Charges
	Parts brought in or shipped in for repairs:	
140B.	Overhaul rear axle	$4.50
141B.	Straighten or repair rear radius rod	.60
142B.	Overhaul differential assembly with shafts	1.50
143B.	Remove old and press new gear on axle shaft—each	.40

FRONT SYSTEM DIVISION

The following charges cover work on cars driven into the service station:

167.	Overhaul front axle, straightening, aligning and adjusting of wheels	$5.00
168.	Rebush spindle bodies and arms—one side $1.50; both sides	2.50
169.	Rebush spindle body—one side $1.00; both sides	1.75
170.	Rebush spindle arm—one side 75c; both sides	1.25
171.	Replace spindle arm or body and line up assembly	1.00
172.	Replace or straighten spindle connecting rod	.60
173.	Replace or straighten steering connecting rod	.60
174.	Replace or straighten front axle (no other repairs)	3.00
175.	Replace broken radius rod ball cap stud	2.50
176.	Tighten radius rod or steering gear ball cap	.60
177.	Replace radius rod	.75
178.	Straighten front radius rod and line up front assembly.	1.00
179.	Replace radius rod ball cap with new style	.60
180.	Tighten all sockets and joints of front end	1.25

SPRINGS

181.	Replace front spring tie bolt or new leaf, including polishing and graphiting of leaves	2.50
182.	Replace front spring or tie bolt only	1.50
183.	Install or tighten front spring clips—one 40c; both	.60
	Operations 167 and 175 combined on one order	6.50
	Operations 167 and 181 combined on one order	6.50
	Operations 167 and 203B combined on one order	6.50
	The following extra charges should be made for special equipment.	
	Overhauling front axle when bumpers, special radius rods, "Little Steersmen," shock absorbers and such devices are used	1.50
	Parts brought in or shipped in for repairs:	
202B.	Straighten front axle	1.50
203B.	Rethread front axle by drilling out and bushing	2.00

Operation Number		Labor Charges
204B.	Straighten radius rod	.60
205B.	Install stud in radius rod	.60
206B.	Rebush spindle body and arm	.75
207B.	Rebush spindle body	.50
208B.	Rebush spindle arm	.40

CHASSIS DIVISION

The following charges cover work on cars driven into the service station:

FRONT END AND FRAME

228.	Replace front cross member	7.50
229.	Replace front cross member when radiator is off	5.00
230.	Straighten front cross member (without removing from car)	2.00
231.	Replace rear cross member	7.50
232.	Replace side member or frame	20.00
233.	Install engine pans—both	1.00
234.	Tighten engine pan	.60
235.	Tighten crankcase front end bearing cap $1.00—1923-24	1.75
236.	Install hood clips or springs on hood board, one side	.60
237.	Free up hand brake lever 75c; when necessary to remove wheel to free up cam or remove quadrant to free bracket	2.00
238.	Remove radiator to replace radiator stud or tighten fender brackets—each or both	1.50
239.	Replace starting crank ratchet pin—old style 60c; new style	.40
240.	Replace starting crank or sleeve	1.00
241.	Install running board bracket—one $2.50; both	4.50
242.	Repair hand brake lever assembly including replacing of pawl	1.50
243.	Replace hand brake lever quadrant without removing running board shield	1.00
244.	Tighten all bolts and nuts on car	3.00
245.	Tighten body bracket bolts	.60
246.	Install tail lamp bracket	.40
247.	Change tire carrier	2.00
258.	Replace one fender or running board (25c extra when necessary to straighten iron or bracket)	1.00
259.	Tighten fenders, running boards, shields and truss rods —one only 40c; all	1.75

Operation Number		Labor Charges
260.	Remove fender or running board and straighten	1.00
261.	Replace running board shield—one $1.25; two	2.00
262.	Install fender to shield bracket—each	.60
263.	Replace rear fender iron	.75
264.	Replace truss rods—one rod 40c; both rods	.60

DASH

276.	Replace dash	5.00
277.	Replace dash when motor is out	1.50
278.	Tighten dash bracket to body and dash	1.00
279.	Replace coil, install new switch on coil box, or repair the box	.60

STEERING GEAR

291.	Overhaul steering gear including replacing of quadrant or gear case and rebushing of bracket	3.50
292.	Overhaul steering gear when motor is out	2.50
293.	Tighten rivets of internal gear case	1.00
294.	Tighten at dash and rebush bracket	1.25
295.	Replace wheel or spider	.60
296.	Tighten at dash and post	.50
297.	Replace steering gear assembly	3.00
298.	Replace steering gear ball arm	1.00
299.	Tighten steering gear case cover	.75
300.	Oil and grease car	1.00

MUFFLER

310.	Change long exhaust pipe—new style	1.25
311.	Replace muffler (old style)	.60
312.	Repair muffler	1.00
313.	Repack exhaust pipe pack nut	.60

GAS TANK AND LINE

323.	Repair leak in touring or sedan gas tank	2.50
324.	Repair leak in touring car gas tank (when necessary to remove body)	6.00
325.	Clean sediment bulb, gasoline feed line and drain carburetor	.75
326.	Repair leak in gas line or replace gas line	.60

Operation Number		Labor Charges
	HOOD	
337.	Install hood leather	.60
	RADIATOR	
348.	Overhaul radiator (requiring 4 to 7 hours' time)	7.50
349.	Install new core in radiator	6.00
350.	Repair radiator, solder one or two tubes and replace one or both sides	4.00
351.	Solder neck or top tank or repair without removing from car	1.00
352.	Solder casting to lower or top tank when necessary to remove radiator	1.50
353.	Replace broken pet cock	.60
	WHEELS	
365.	Change hub, rear or front	1.25
366.	Replace wheel and tire—each	.75
367.	Adjust and dope front wheels	.60
368.	Remove front wheels and replace bearing parts—1 wheel 75c; both	1.25
369.	Replace spindle arm	.60
	PAINT DIVISION	
391.	Repaint and revarnish chassis only	12.00
392.	Repaint and revarnish car—touring or runabout	25.00
393.	Repaint and revarnish coupe	35.00
394.	Repaint and revarnish sedan	45.00
395.	Repaint and revarnish body only—touring or runabout	15.00
396.	Revarnish body only—touring or runabout (on chassis)	5.00
397.	Revarnish body only—sedan or coupe (on chassis)	12.00
398.	Refinish deck on runabout	1.50
399.	Refinish fenders, dust shields, running boards, wheels, or hood, when removed from car, each	.75
	BODY DIVISION	
411.	Tighten all doors—any type car	1.25
412.	Install new lock—touring or runabout—each	1.00
413.	Replace sedan door lock	1.50
414.	Replace top irons—each (old style)	1.00
415.	Install new leather on door panel—one 60c; two	.75
416.	Install new leather on arm rest	1.00

Operation Number		Labor Charges
417.	Patch section of upholstery	1.00
418.	Re-upholster touring body (using new material)	15.00
419.	Re-upholster runabout body (using new material)	8.00
420.	Change closed body	9.00
421.	Change touring or runabout body	5.00
422.	Take dent out of any side panel	4.00
423.	Take dent out of any side panel and refinish	6.00
424.	Take dent out of door	3.00
425.	Take dent out of door and refinish	4.00
426.	Take dent out of rear or corner panel (without removing from car)	8.00
427.	Take dent out of rear or corner panel and refinish (without removing from car)	10.00
428.	Take dent out of rear or corner panel (when removed from car)	13.00
429.	Take dent out of rear or corner panel and refinish (when removed from car)	16.00
430.	Take dent out of runabout deck and refinish	2.00
431.	Repair front or rear seat cushion	2.50
432.	Replace binding on one or more doors	.75
433.	Put on new trim rail	2.50
434.	Replace door hinge	.75
434A.	Install new window lift rod or spring	1.50

TOP AND WINDSHIELD DIVISION

455.	Overhaul touring car or runabout top (including recovering, lining up, and fitting of curtains)	8.00
456.	Replace top deck or side quarters—each or both	5.00
457.	Line up and dress top	3.00
458.	Install and fit top and curtains	3.00
459.	Repair tear in top up to 4″	1.00
460.	Replace front or rear bow touring or runabout	3.00
461.	Replace center bow—touring or runabout—each	1.25
462.	Patch small pin holes	.60
463.	Patch hole in curtain or replace celluloid	.60
464.	Replace back curtain—old style $1.50; new style	2.00
465.	Replace celluloid in back curtain—old style $1.75; new style	2.50
466.	Refit complete set of side curtains	2.00
467.	Refit one side curtain 60c; two	.75
468.	Replace top bow socket—touring or runabout	1.25

Operation Number		Labor Charges
469.	Replace windshield—and line up windshield frame	1.00
470.	Replace windshield glass—upper	1.00
471.	Replace windshield glass—lower	1.00
472.	Replace hinge	.60
473.	Replace or tighten dash clips and hinge screws	.50
474.	Pack windshield glass to take out rattle—each.....	1.00
475.	Replace windshield bracket	1.00
476.	Repair windshield lower frame and install glass.....	1.75

LAMP AND HORN DIVISION

502.	Replace or repair electric headlight switch	.60
503.	Straighten damaged headlamp	1.25
504.	Take dent out of headlamp door frame and replace glass	.75
505.	Clean up and repair set of oil lamps	1.00
506.	Install electric horn and wire	1.00
507.	Install electric headlights and wire	1.50
508.	Install new parts in oil lamp—each	.60
509.	Remove short-circuit from switch or lamp	1.00

TRUCK CHASSIS

95A.	Install new frame (when necessary to remove body and cab)	25.00

TRUCK REAR SYSTEM DIVISION

The following time covers work on trucks driven into the service station:

96A.	Overhaul complete rear axle assembly	12.00
97A.	Repair or replace drive shaft tube	7.00
98A.	Repair or replace one rear radius rod	3.00
99A.	Replace rear spring—one $3.50; both	5.00
100A.	Remove front and rear springs, polish and graphite leaves	7.00
101A.	Replace spring perches—one $1.50; both	2.75
102A.	Rebush springs and perches	4.00
103A.	Install universal joint	5.50
104A.	Tighten rear radius rod	1.75
105A.	Install felt, and steel washer, one side $1.25; both	2.25
106A.	Install brake shoe and equalize brakes—one $1.25; both	2.25
107A.	Tighten universal ball cap bolts	.75
108A.	Install or tighten rear spring clips	1.50

Operation Number		Labor Charges
109A.	Tighten rear hub lock nut	.50
110A.	Fit new key in taper—each	.50
111A.	Replace pull rod support—one 50c; both	.75
112A.	Replace or rebush hub brake cam—each	2.50
113A.	Replace rear axle assembly	5.00
114A.	Adjust pull rods or replace one	1.25
115A.	Straighten rear radius rod in truck	1.50
116A.	Install outer roller bearing—each	1.50
117A.	Replace rear axle shaft, drive shaft, worm or worm gear (no other work necessary)	8.00
	Parts brought in or shipped in for repairs:	
140B.	Overhaul rear axle complete	8.00
141B.	Overhaul differential and housing assembly	3.75
142B.	Overhaul drive shaft and tube assembly	2.00
143B.	Replace worm or shaft	.75
144B.	Replace ball bearing or differential case	.75
145B.	Rebush drive shaft housing	.75
146B.	Tighten or replace parts on universal joint	.75
147B.	Replace differential gear or axle shaft—each	.40
148B.	Repair or straighten rear radius rod	.75

STARTING, LIGHTING AND IGNITION DIVISION

The following charges cover work on cars driven into the Service Station:

520.	Install starting and lighting system	7.00
521.	Replace instrument board (open jobs)	1.25
522.	Replace battery bracket	1.00
523.	Replace starting motor	1.00
524.	Replace generator	.60
525.	Replace cutout	No Charge
526.	Replace ammeter	.60
527.	Replace ignition switch	.60
528.	Replace foot switch	.75
529.	Replace bendix drive	.75
530.	Replace ignition wire loom	.60
531.	Replace switch to terminal block loom	.60
532.	Replace terminal block to head and tail light loom	.60
533.	Replace switch to motor cable	.40
534.	Replace battery to switch cable or ground cable—each	.60
535.	Replace ammeter to switch or cutout wire (one or both)	.50

Operation Number		Labor Charges
536.	Overhaul starting motor	3.00
537.	Overhaul generator	3.00
538	Repair and adjust cutout	.40
539.	Set or replace third brush	No Charge
540.	Clean motor or generator commutator	No Charge
541.	Replace commutator or brush	.50
542.	Coils units—test, adjust and replace points when necessary—each	.25
543.	Replace commutator pull rod	.40
544.	Replace head lamp	.60
545.	Adjust head lamp (installing bulbs when necessary)	No Charge
546.	Straighten damaged head lamp	.60
547.	Install lens or reflector (one or both)	No Charge
548.	Replace and adjust horn	.60
549.	Clean and repair set of oil lamps	.60
549A.	Repair Bendix	1.00
550.	Stop oil leaks around generator or starting motor	1.00
551.	Replace starter or battery cable	.75
552.	Install dash lamp	.60
553.	Install stop light	1.25
	Parts brought in or shipped in for repairs:	
560.	Overhaul starting motor	2.00
561.	Overhaul generator	2.00
562.	Repair and adjust cutout	.40
563.	Install field coils in motor or generator yoke	.75
564.	Adjust or replace third brush	No Charge
565.	Replace bushing in motor brush and bracket or in mounting bracket	.75
566.	Replace gear or generator	.40
567.	Replace bearing (1 or 2) on generator armature	1.00
568.	Install spacer or motor shaft (old style)	.40
569.	Remove ball bearing stuck in bracket	.40
570.	Remove dents from head lamp, door or body	Make Proper Charge
571.	Install lens or reflector (1 or 2)	No Charge
572.	Coil units—test, adjust and replace points when necessary—each	.25
573.	Tighten or remove dent from horn	.25

FORD BATTERY

Operation Number		Labor Charges
580.	Install new separators, 1 cell (including material and recharging)	3.00
581.	Install new separators, 3 cells (including material and recharging)	5.00
582.	Positive group renewal, 3 cells (including material and recharging)	11.00
583.	Positive group renewal, 1 cell (including material and recharging)	5.00
584.	Positive group renewal, 1 cell (including new separators in all 3 cells and recharging)	6.00
585.	Install new case in battery (including material and recharging)	2.25
586.	Reseal battery	1.25
587.	Change cracked jar (including material)	2.75
588.	Change two cracked jars (including material)	4.00
589.	Change three cracked jars (including material)	5.25
590.	Change cracked cover (including material)	1.75
591.	Rebuild terminal post	.75
592.	Clean corroded terminals and apply vaseline	.50
593.	Recharge battery	.75
594.	Remove and install loaner	.25
595.	Loaner battery—per day	.25

SPECIAL

600.	Tow-in per mile (each way)	.50
601.	Start-up (add for each additional mile 15c)	.60

CHAPTER X

LATEST FORD CAR AND FORDSON TRACTOR INFORMATION.

Body Design Changes—Greater Driving Comfort—Coil Box Moved to Engine—Improved and Enlarged Brakes—Gasoline Tank Under Cowl—Hood is Larger—Upholstery of New Models—Doors Are Wider—New Type Transmission Band—Lower Steering Gear Reduction—Ford Generator and Battery Troubles—Setting Third Brush—Making Hydrometer Readings—Lubricating the New Ford—Specifications of Fordson Tractor—Fordson Tractor Ignition System—Locating Ignition Trouble—Adjusting Late Type Fordson Vaporizer—Fordson Tractor Brake—Removing and Adjusting Tractor Clutch—Removing New Style Cowl Tank—Installing New Type Transmission Cover—Removing and Installing New Type Lined Wheel Brake.

Body Design Changes.—Body changes and chassis refinements more pronounced than any made since the adoption of the Model T chassis in 1908 have been announced for 1926 by the Ford Motor Company. With the announcement came the statement in Automotive Industries that there would be no change in present prices. Outstanding features of the improvements in both open and enclosed types are lower and longer all-steel bodies on a chassis which has been reduced 1½ in. in height; complete new design in most body types; a change from black to green and maroon in the closed cars; larger, lower fenders; newly designed seats and larger and more powerful brakes. The composite wood framework and steel panel construction is retained in the Fordor body, this model being clearly shown at Fig 170.

The increased length of the improved models is still further accentuated by the new body lines in combination with a higher radiator and redesigned cowl. The radi-

ator is 5/8-in. higher. Wide crown fenders hung close to the wheels contribute to the general effect of lowness and smartness. While the runabout and touring car remain in black, the closed bodies are finished in colors and have nickel finished radiator shells. The Coupe and Tudor

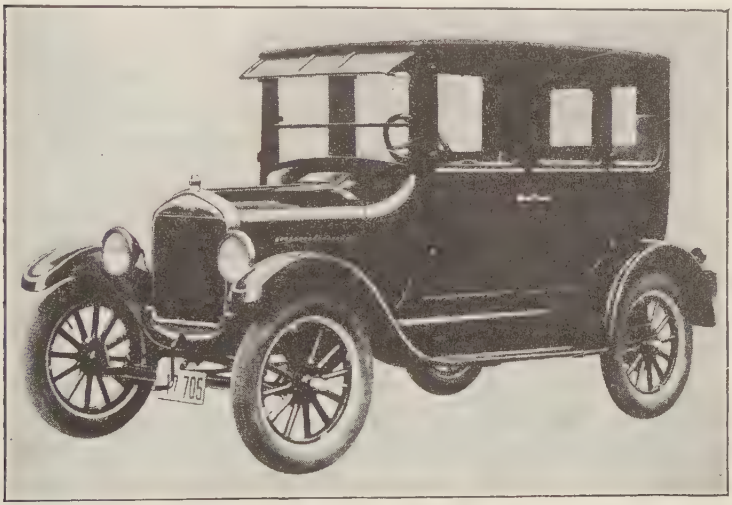


Fig. 170—Front View of Fordor Sedan, Showing Higher Radiator, New Mudguards and Balloon Cord Tire Equipment.

bodies are in deep channel green, while the Fordor is finished in Windsor maroon.

Greater Driving Comfort.—Greater comfort is provided for driver and passengers in both open and closed cars by larger compartments, more deeply cushioned seats and greater leg room. In all models except the Fordor, the gasoline tank is under the cowl and is filled through a filler hidden from sight by a cover similar in appearance to a cowl ventilator. One-piece windshields and narrowed pillars in the Tudor and Coupe give better visibility and ventilation.

Driving comfort has been increased by lower seats, improved back rests and lower steering wheel. Brake and clutch pedals are wider and more conveniently spaced. The open models now have a door at the left of the driver and side curtains, held secure by rods, open with the doors. Cord tires are standard equipment on all models, balloon cords being furnished as an option at extra cost. The reduction of 1½ in. in the chassis height has been effected without materially decreasing the road clearance by lowering the crown of the springs one inch and by raising the front wheel spindles ½ in. on the spindle bodies.

Coil Box Moved to Engine.— The coil box has been removed from the dash and now is mounted on the left-hand side of the engine, which change makes it unnecessary to enter the driving compartment to make adjustments. This arrangement is similar to that used for some time on the Fordson tractor power plant. The fan has been raised and the adjustment for belt tension improved. The fan bracket is now an integral part of the cylinder head outlet and is provided with an eccentric adjustment.

Improved and Enlarged Brakes.—One of the most important improvements is in the brakes. The transmission brake band has been increased from 1⅛ to 1¾ in. in width, this change resulting in smoother braking and in longer life and less frequent adjustment of the bands. All transmission bands now have removable ears to facilitate replacement and hardened steel shoes have been placed over the clutch casing keys to prevent wear.

Brake drums at the rear axle have been increased to 11 in. in diameter from 8 in. and the width has been increased from 1 to 1½ in. The brake shoes now are covered with an asbestos composition material eliminating

the old method in which braking was effected by direct contact of cast iron shoes. The brake and clutch pedals in addition to having wider surfaces and being spaced further apart, have been provided with flanges at the side to prevent slippage of the driver's foot.

In all models except the Fordor, the steering wheel has been dropped three inches for greater ease of driving as the seats have been moved back and lowered. The steering wheel on all models is 17 in. in diameter and the steering gear reduction is 5 to 1.

Gasoline Tank Under Cowl. — The new gas tank location under the cowl, which is used in all models except the Fordor, feeds gasoline to the carburetor at an abrupt angle and insures fuel supply even on the steepest grades. A large trough and overflow pipe has been provided at the filler to carry any spillage directly to the ground. This change places the sediment bulb on the tank under the hood in a readily accessible position. Adequate separation of the fuel tank from the engine is provided by the dash.

The new crown fenders, well illustrated in Figs. 170 and 171, in addition to being wider and larger, extend further down front and rear to afford better protection against splashing. The running boards on all models are wider and nearer to the ground.

Standard accessory equipment on all closed cars includes windshield wiper, rear view mirror, windshield visor and dash light. The dome light is continued in the Fordor and windshield wipers are supplied on the open models.

On the Tudor and Coupe, the windshield is a one-piece design opening forward. A passageway at the base of the shield directs ventilation downward into the front

compartment when the windshield is slightly opened. The open models have a double ventilating type of windshield, both halves opening, and the Fordor shield has been redesigned to conform with the new cowl. The

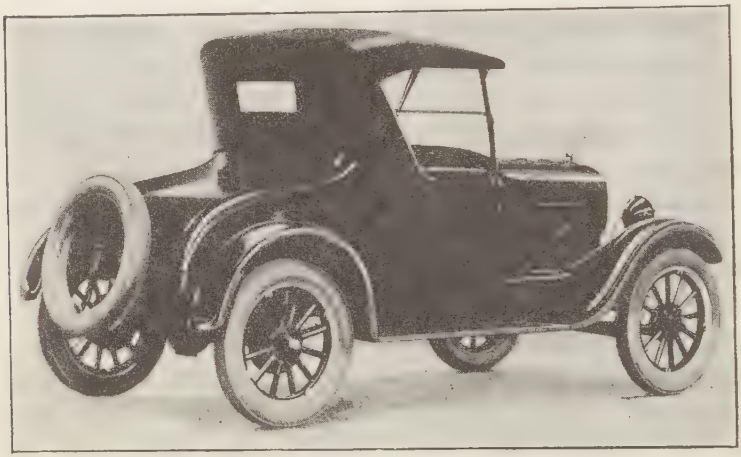


Fig. 171—Rear View of Ford Model T Two-Passenger Open Body, Showing New Rear Deck and Three Arm Tire Carrier.

lower half of the windshield on this model is stationary and there is no cowl ventilator as before.

Hood Is Larger.—The radiator is 5/8 in. higher and the hood is larger with more louvres. The closed model windows are plate glass and lower flush with the moldings, conveniently located lifters being provided for the purpose. Doors on all models open forward with the exception of the rear doors of the Fordor.

A new design of arm type tire carrier is provided which accommodates either the new Ford wire wheels or the demountable rim, and is clearly shown in Fig. 171. The headlights have polished nickel rims, are set higher and further apart, and are attached to pressed fender

supports. On all body types, the tail light and license plate bracket are now located on the left rear fender.

Upholstery of New Models.—Tudor upholstery is gray fabric with a fine green stripe to harmonize with the deep channel green exterior finish. Head linings are gray as is the silk back curtain and the carpet is greenish gray. The height of this body from top to road has been reduced four inches and its length has been increased 3½ in. The seats are 2½ in. lower from top of seat to floor and this with the 1½ in. drop in the frame brings them 4 in. nearer the ground. To provide more leg room, the distance from the back of the front seats to the front of the rear seat has been increased two inches.

In the Coupe, shown at Fig. 172, which has the same upholstery as the Tudor, the rear deck has been made the full width of the body and extends well back over the rear spring with fenders bolted to the body, with resultant increase in the storage space available at this point. The shelf at the back of the seat is five inches deeper and the doors also are broader. The overall height of this body has been reduced 4½ in. and it is 3½ in. longer. The reduction in seat height is the same as in the Tudor.

In the Fordor model, the upholstery fabric is gray with a fine red stripe to match with the new maroon exterior finish. Head linings and silk window curtains are gray and the carpet also is gray with a suggestion of red. The height of this model is 1½ in. less, due to the chassis changes, but otherwise there are no other dimensional alterations.

The rear deck of the Roadster, shown at Fig. 171, has been redesigned along the same lines as the Coupe. This model now has two doors, both of which are wider. The seat has been redesigned to give more comfort and a re-

duction of 2½ in. in its height from the floor has been made. This model is 4½ in. lower from top to road, 7¾ in. longer and its seat is 3 in. wider.

Doors Are Wider.—The touring model also has a door at the driver's left and all four doors are wider. Seat contours have been improved and their tops are 2½ in. nearer

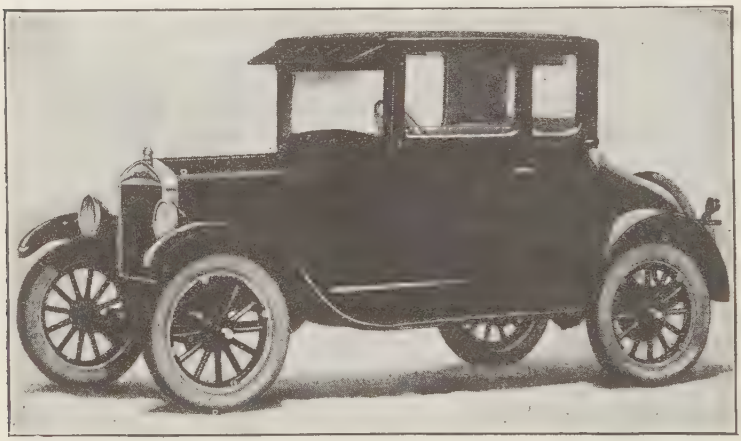


Fig. 172—The Ford Model T Coupe, Showing New Mudguards and Nickel-plated Radiator Shell.

the floor. Three inches has been added to the width of the front seat and five to the rear. A reduction of 4½ in. has been made in the overall height of this model and 3½ in. has been added to its length. The distance between the back panel of the front seat and the front of the rear seat has been increased 3½ in.

In bringing out the improved models, the Ford Motor Co. is cautioning its dealers throughout the country against the use of the word "new." It is pointed out that, while it is true certain refinements have been added to the chassis and that these are more radical and more

conspicuous than any which have heretofore been made, the Model T chassis, though lower, remains basically the same in design and construction as it has been since 1908. The objection to the use of the word "new" is based on the fact that it implies a redesigning of the chassis as well as the body. As far as can be ascertained at this time there has been no change in the powerplant, notwithstanding the many rumors that have been circulating recently in automotive circles and no changes have been spoken of by the makers. As a matter of fact, changes are not to be spoken of lightly when a factory is equipped with special production machinery that makes 10,000 cars a day output possible.

It is apparent that the efforts of the Ford engineers have been concentrated chiefly on obtaining greater beauty and comfort in design. An analysis of the cars shows that most of the changes have been influenced by this factor. The only important mechanical change has been made in the brakes. Greater convenience and comfort for driver and passengers has resulted from moving the fuel tank to its new position under the cowl, increasing the size of the seats and providing more leg room, lowering the steering wheel, adding an extra door to the Touring car and Runabout, and placing the brake and clutch pedals farther apart and providing each with a flange at the side to prevent the foot from slipping.

New Type Transmission Bands.—It is no longer necessary to remove the transmission cover to change the new type of bands. A detachable ear on one side allows the bands to be withdrawn and replaced through the transmission cover door as shown at Fig. 173. The ear is held in place by studs in the ear slots, the shoulder of the ear snapping over the end of the brake band, thus holding it securely

in place. To remove the ear it is only necessary to insert a tool, which is made by bending over the end of a screwdriver one-quarter of an inch, through the end of the ear into the square hole in the end of the brake band, lifting up on the tool and forcing the band down and the ear back.

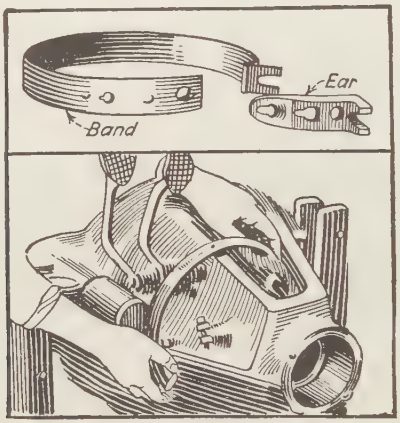


Fig. 173—Upper View Shows the New Style Transmission Band with Detachable Ear; Lower Illustration Shows Method of Removal without Taking Off Upper Part of Transmission Case.

After the nuts, washers and springs have been removed from the pedal shafts, the reverse and brake pedals are pulled out as far as possible, removing the ears as explained. The bands then may be withdrawn from the right side, permitting them to follow close to the cover to prevent their distortion. Where a car is equipped with the old type of bands, the transmission cover must be removed. The slow speed shaft must be cut off about 7/8 of an inch from the shoulder and the new type slow speed adjusting screw installed.

New Steering Gear Reduction.—Steering gears of 5 to 1 ratio, originally installed only in cars equipped with

balloon tires, now are being used on all cars regardless of tire equipment. A new steering wheel, 17 inches in diameter, is used with the improved steering gears, which, together with the increased ratio, adds materially to steering control. The gears used in the new 5 to 1 steering arrangement are not interchangeable with the

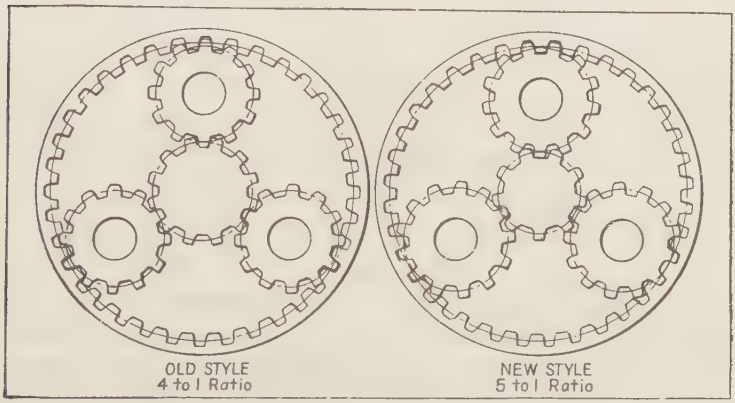


Fig. 174—Diagrams Outlining Difference Between Old and New Planetary Reduction Gearing in Steering Gear.

old 4 to 1 type, and it is important that mechanics understand the difference in the gears of the two ratios to prevent accidents due to locking. The arrangement of the reduction gears can be clearly ascertained by referring to Figs. 174 and 175.

Ford Generator and Battery Troubles.—The Ford generator is of the simplest possible construction. Fig. 176A shows the parts in their relative position after the generator has been taken apart. Indications of trouble in the generator are first ascertained by reading the ammeter on the instrument board. At normal driving speeds (about twenty miles per hour) the pointer or needle

should register between 8 and 12 amperes charge on the scale. If there is less charge than this or no charge, the difficulty may result from a fault in the generator, the cutout, or the external circuit wiring.

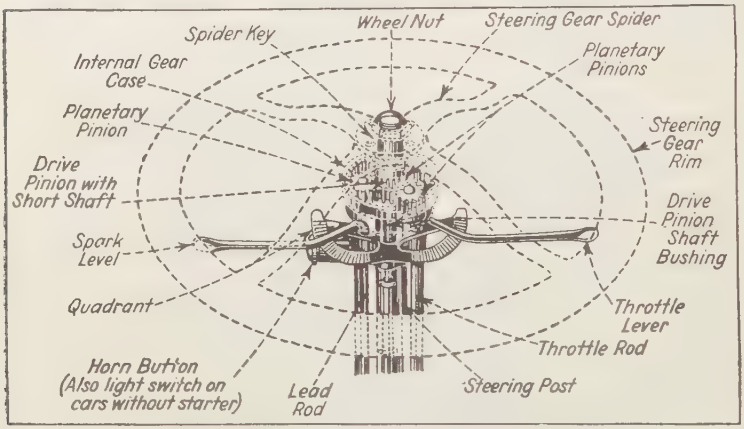


Fig. 175—The Latest Type of Ford Steering Gear, Showing Planetary Reduction Gearing and Its Relation to Handwheel.

Trouble in the external wiring is due to one of the following causes, which may be found by careful inspection:

(a) Poor or loose connection at the terminals in the wiring circuit between the generator and the battery.

(b) Broken wire, either at the terminal or inside the insulation.

(c) Grounded wire due to defective insulation.

To determine whether or not the trouble lies in the generator attach the positive (+) wire of a direct current (D. C.) meter registering from 0 to 30 volts, to the terminal on the generator, and the negative (—) wire to the yoke (housing) of the generator. With the engine running at a normal speed (twenty miles per hour) the instrument should read 7 volts or more.

If a voltmeter is not available another method used for determining whether or not the trouble lies in the generator is by grounding the generator terminal by connecting it with the generator yoke, using a screw driver or some other piece of metal to short circuit the current. If no spark occurs at the moment of grounding, the generator is not producing electricity.

If the voltmeter tests show less than 7 volts, disconnect the wire attached to the cutout and unscrew the three cap screws which hold the generator to the gear case. The generator is now free of the engine and may be removed by prying it off with a screw driver, forcing the generator out and down until the gears disengage. The generator may then be taken to a bench and inspected with more convenience.

The trouble may be due to one of the following causes: (1) dirty commutator, (2) brush spring weak or binding, (3) brushes not seating properly, (4) brushes not touching commutator, (a) held up by spring, (b) sticking in holder, (c) worn too short; (5) short-circuited in the armature or field, (6) ground in brush wires, field or armature, (7) open circuit in field, armature or brushes.

Besides the electrical trouble, the generator is subject to mechanical wear, as follows: (1) commutator, (a) segments rough, (b) under-size brushes (brushes rubbing on mica); (2) ball bearings broken or worn, (3) brush ring loose and shifting, (4) third brush carrier shifting.

Setting Third Brush.—First, shift the third brush A (Fig. 176-B) to the left as far as possible; that is, toward the engine; then loosen the four screws which lock the brush holder assembly in position approximately half a turn, which will allow the brush holder assembly C to be

moved freely in each direction; care should be taken not to run out these screws more than is actually necessary to allow the brush holder assembly to move freely. (If the screws are run out too far, the clamp ring D will fall off inside the generator, and to replace it would necessitate removal of the generator.) Next start the engine, opening the throttle until the engine is running at a speed equivalent to approximately twenty miles per hour; then

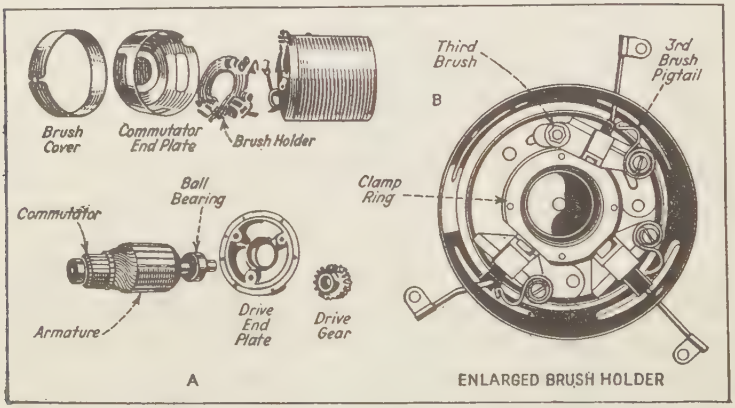


Fig. 176—How the Parts of the Ford Generator Look When it is Dismantled, Shown at A. View at B Shows Enlarged Commutator End Plate with Brush Holder in Place.

rotate the brush holder assembly until the ammeter indicates the maximum output; tighten the four screws which hold the brush holder assembly in position, next shift the third brush until the ammeter shows twelve amperes charge and then tighten the third brush nut.

Once the adjustment has been set and the four screws tightened, the adjustment should never be changed unless a new armature or brush holder assembly is installed. It is, of course, understood that the third brush can be shifted to meet varying conditions; for instance, a car

that is driven only on short trips, necessitating frequent starting with consequent drain on the battery, would require a higher charging rate than the car that is driven only on long runs. For average conditions, however, a charging rate of twelve amperes is the most suitable.

If for any reason the engine is run with the generator disconnected from the battery, as on a block test, or when battery has been removed for repair or recharging, be sure that the generator is grounded by running a wire from the terminal on generator to one of the dust cover screws in the yoke. Two strands of shipping tag wire may be used for this purpose. Be sure that the connections at both ends of the wire are tight. Failure to do this when running the engine with the generator disconnected from the battery will result in serious injury to the generator. *Never ground the generator through the cut-out.*

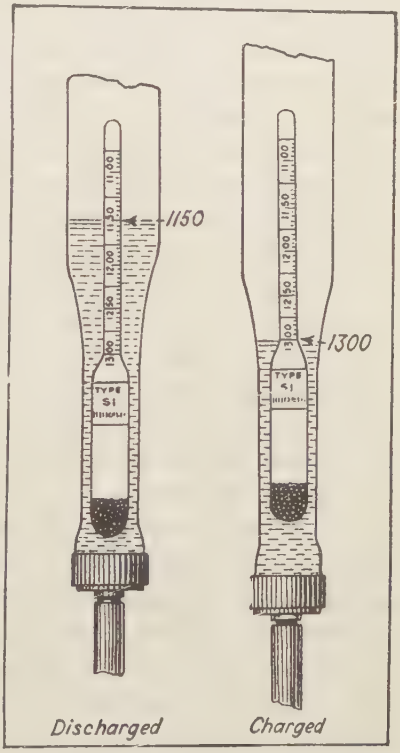


Fig. 177—Hydrometer Readings of Discharged and Charged Storage Battery. Electrolyte Indicates Condition.

Making Hydrometer Readings.—Hydrometer readings should be taken about every two weeks, as shown on page

315, Fig. 122, to make sure that the generator is keeping the battery charged. To take a hydrometer reading, remove the filling plugs (remove the plug from only one cell at a time). Next, insert the hydrometer syringe in the filler tube and draw up enough of the solution to float the glass bulb inside the instrument. The reading of the scale at the surface of the liquid (see Fig. 177) gives the strength of the solution. Be sure to return the electrolyte to the cell from which it was taken. Following is a list of the readings with their indications. The readings in parentheses apply to batteries used in tropical climates where water never freezes. Readings of 1.275 (1.200) or more indicate a fully charged battery. Readings of less than 1.225 (1.130) but more than 1.150 (1.080) indicate complete discharge. Hydrometer tests taken immediately after filling with water and before it has become thoroughly mixed with the electrolyte will not show the true condition of the battery. If the hydrometer reading shows the battery less than one-half charged, it should be taken to the nearest authorized Ford Dealer for recharging. Continued operation in a less than half-charged condition is injurious to the battery somewhat as running on a soft or deflated tire is injurious to the tire. Before replacing the battery, the cause of the discharged condition should be removed. It may be due to leaks or grounds in the car wiring or to the electric system having gotten out of adjustment so that the battery is not kept supplied with the proper amount of current from the generator. If the reading in one cell is more than 50 points different from the others, it indicates that the cell is not in good order.

Add nothing but pure water to the cells and do it often enough to keep the plates covered at all times. The solu-

tion (electrolyte) should be maintained at a level with the bottom of the filling tube. Distilled water, melted artificial (but not natural) ice and rain water, if obtained in the open country from a clean slate or shingle-covered roof, are generally satisfactory. All water for battery use should be kept in clean, covered vessels of glass, china, earthenware, rubber or lead. In cold weather add water only immediately before running the engine so that the charging will mix the water and electrolyte, and avoid freezing. If, for any reason, it is necessary to add acid, the battery should be taken to an authorized Ford Dealer, or any competent storage battery specialist.

Keep the filling plugs and connections tight and the top of the battery clean. Wiping the battery with a rag moistened with ammonia will counteract the effect of any of the solution which may be on the outside of the battery. A coating of heavy oil or vaseline will protect the connectors from corrosion. It is of vital importance that the battery is firmly secured in its supporting brackets at all times. If clamps are loose, the battery will shift about in the compartment and result in loose connections, broken cells and other trouble. If repairs are necessary or if the car is to be laid up for the winter, take the battery to a skilled service man for proper attention and storage. Do not entrust the battery to inexperienced or unskilled hands.

Lubricating the New Ford.—A chart is presented at Fig. 178 which outlines the principal points of the Ford chassis needing lubrication and represents the advice of the factory service experts. Careful study of this chart will prove valuable. All oil cups should be supplied with the same light grade lubricating oil used in the engine and all "dope" cups should be filled periodically as indi-

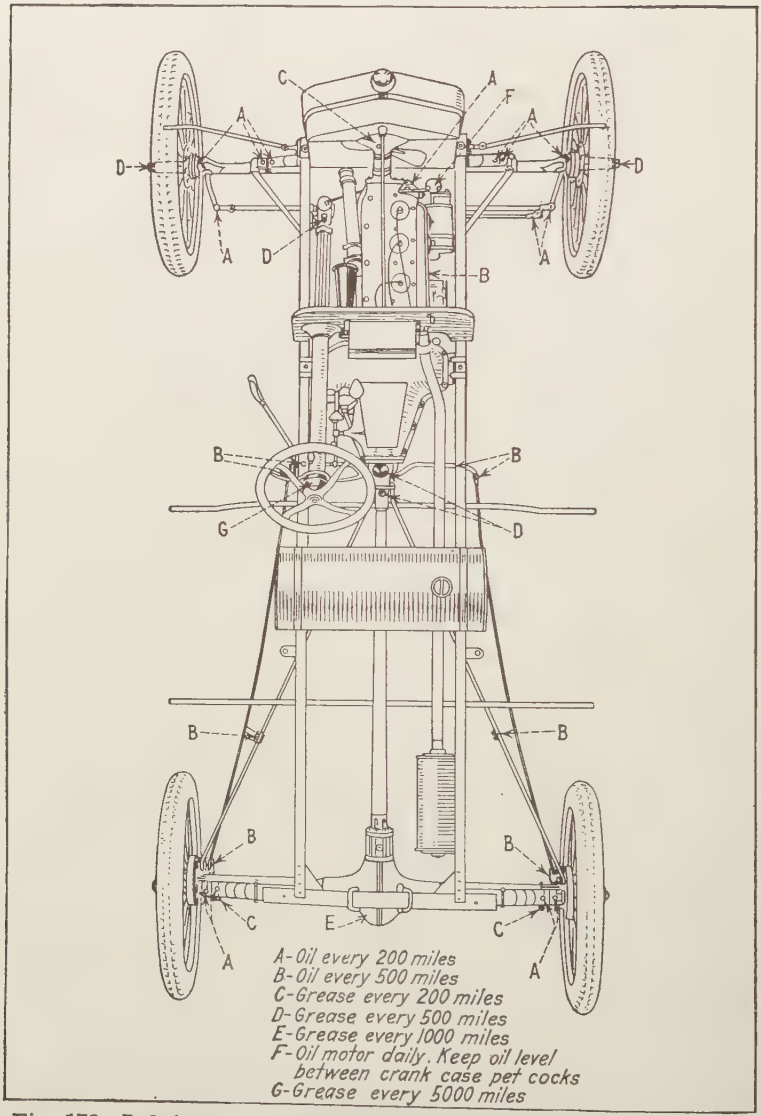

A-Oil every 200 miles
B-Oil every 500 miles
C-Grease every 200 miles
D-Grease every 500 miles
E-Grease every 1000 miles
F-Oil motor daily. Keep oil level between crank case pet cocks
G-Grease every 5000 miles

Fig. 178—Lubrication Chart Outlining Points Needing Oil on Late Model Fords, and Periods when Oiling is Necessary.

cated with good, free-flowing cup grease. The commutator should be kept freely supplied with oil at all times and should be cleaned out of "gummy" oil about every 500 miles, wiped clean with a cloth and reoiled with fresh lubricant.

When it is advisable to fill dope cup covers, screw them down, refill with grease and repeat the operation two or three times. Always open oil cups by turning to right as this keeps tightening rather than loosening them. A drop of oil now and then in crank handle bearing is necessary. The Ford Motor Company recommends only medium light high grade gas engine oil for use in all Model T motors when new. In cold weather, a light grade of oil having a low cold test is absolutely essential for the adequate lubrication of the engine. Graphite should not be used in either engine or transmission as it will have the effect of short circuiting the magneto.

It is advised by the factory experts to clean out the crank case by draining off the dirty oil when the new car has been driven 350 miles, thereafter it will only be necessary to repeat the operation about every 750 miles. Remove the plug under the flywheel casing and the oil will run out. Replace the plug and pour about one gallon of kerosene in through the breather pipe. Turn the engine over with the starting motor for about fifteen or twenty seconds, or with the hand crank for thirty or forty revolutions, so the splash from the kerosene oil will cleanse all internal engine parts. Again remove the crankcase plug and drain off the oil. Make sure that all kerosene is removed from the depressions in the crank case by putting a quart of lubricating oil into the motor after drain plug is replaced and turn the engine crank shaft over several times as previously recommended to

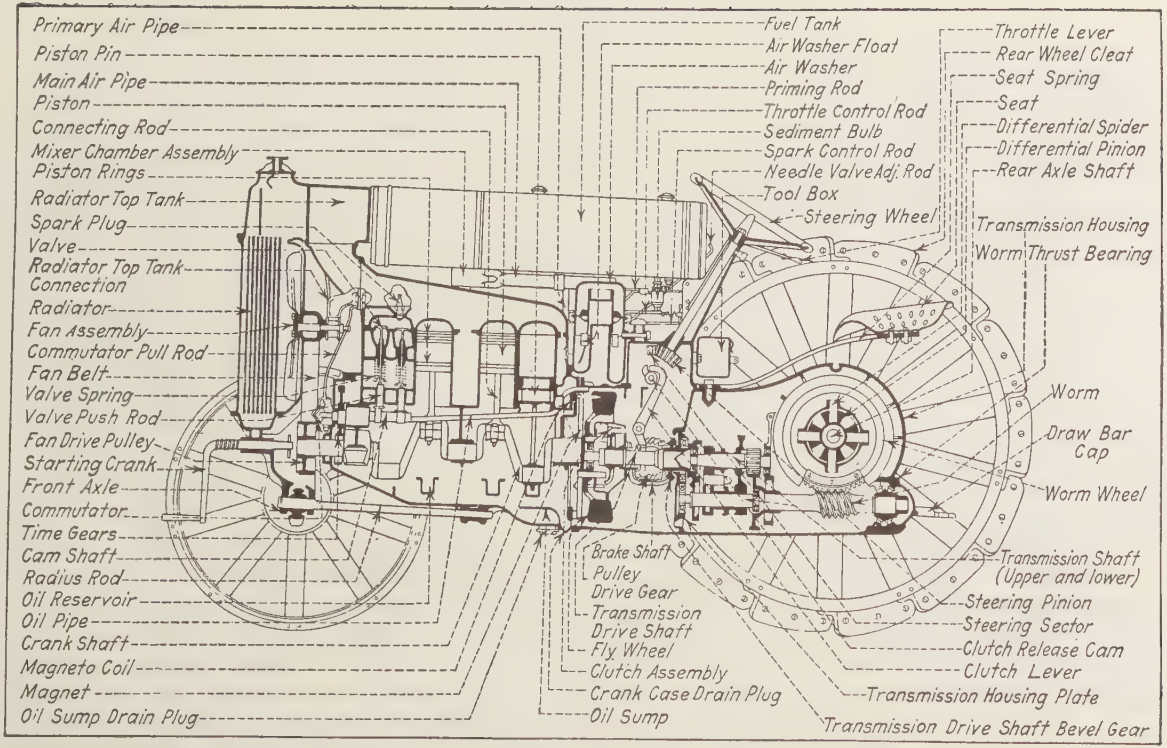


Fig. 179—Sectional View Showing Construction of Latest Type Fordson Tractor and Relation of Important Parts.

Specifications—*Fordson Tractor*

MOTOR—Four cylinder, four-cycle, cylinders cast en bloc. Cylinder bore is four inches; piston stroke, five inches. Firing order of cylinders is 1, 2, 4, 3. There are three main be rings two inches in diameter by three inches long. Connecting rod bearings are two inches in diameter by 2¼ inches long. Piston displacement, 251.3 cubic inches; piston clearance: top .0150, skirt .0045. Valves have a $\frac{1}{8}$″ lift. Inlet opens 10° past upper dead center with piston $\frac{1}{4}$″ above top of cylinder; inlet closes 40° past lower dead center with piston 4½″ to 4$\frac{13}{32}$″ below top of cylinder. Exhaust opens 30° ahead of lower dead center with piston 4$\frac{11}{16}$″ to 4¾″ below top of cylinder; exhaust closes on upper dead center with piston $\frac{1}{4}$″ to $\frac{1}{8}$″ above top of cylinder. Tappet clearance is .007 to .022. Valves are made of special alloy steel.

Lubrication—Splash system. The oil circulation is maintained by oil thrown off the flywheel by centrifugal action. Capacity 2¼ gallons, heavy gas engine oil. Oil temperature when pulling steady maximum load 150° to 200° Fahr. Tractor Lubricating Oil of the following specifications should be used in the transmission both summer and winter:

Color	Flash	Fire	Viscosity		Cold set
Not Darker Than	Open Cup °F.	°F.	Saybolt-Universal 100°F. 210 F.		°F
No. 5	400 (Min.)	450 (Min.)	650 (Max.)	66 (Min.)	45 (Max.)

Oil of the above specifications should also be used in the engine during the summer, but during the winter months, in order to facilitate starting, it is advisable to use oil of the following specifications in the engine:

Color	Flash	Fire	Viscosity		Cold set
	(Open) °F.	°F.	Saybolt-Universal 109° F. 210° F. 300° F.		°F.
No. 4	370 (Min.)	420 (Min.)	300 (Max.)	50 (Min.)	30 (Max.)

COOLING—Thermo-syphon system. The very large water jackets and radiator tanks used with a vertical tube radiator insure a continuous flow of water and efficient cooling. This works in connection with a belt-driven ball bearing fan delivering 1700 cubic feet of air per minute. Water capacity of cooling system, 12 gallons. Cylinder water inlet is 2¾″ diameter outlet approximately 4″ diameter.

FUEL—Supplied by gravity from a 20 gallon overhead tank.

AIR WASHER—Float type, 7 quarts capacity. The air supply is drawn through water, which removes all dust, thus reducing wear on cylinder walls.

TRANSMISSION—Constant mesh selective type, three speeds forward and one reverse. All shafts run on ball bearings. Clutch—multiple disc, 17 hardened discs running in oil. Lubrication—capacity 3¾ gallons. See oil specifications under "Motor Lubrication" above.

TRANSMISSION GEARS—Speeds based on 1000 R. P. M. of Engine.

Gear	Final Ratio	Worm Speed	Axle Speed	Tractor Speed
Low	81.87	207.7	12.23	1.53 M. P. H.
Intermediate	44.46	382.3	22.49	2.81 M. P. H.
High	17.74	958.3	56.36	6.93 M. P. H.
Reverse	46.39	366.4	21.56	2.69 M. P. H.

REAR AXLE—Semi-floating, four-pinion differential running on ball bearings.

FRONT AXLE—Drop forged and heat treated. It is attached in the center directly to the front of the motor, giving a three-point suspension to the tractor.

WHEELS—Front wheels have steel spokes cast in the hub and riveted to rim; they are mounted on adjustable roller bearings. Rear wheels have spokes cast in the hub and riveted to the rim.

WEIGHTS—Weight of tractor less driver, water, oil and lugs, 2425 pounds. Total weight of tractor, including all liquid supplies and 150 pound driver, 2920 pounds. Distribution of above weight: front wheels, 1063 pounds; rear wheels, 1857 pounds. Weight of engine with vaporizer and coils, 651 pounds.

DIMENSIONS—Wheel base 63″; distance between front rims 40⅛″; distance between rear rims 37⅜″; width of front rim 5″; diameter of front rim 28″; width of rear rim 12″; width of extension rim 7″; diameter of rear rim 42″ (3″ cleats riveted on rim); overall length of tractor, 102″ Overall width of tractor 61⅜″; overall height of tractor 54¾″; ground clearance 11¾″; height of draw bar from ground 12″; adjustment—lateral, 7″; vertical none.

BELT PULLEY—Width 6½″; diameter 9½″. Gears, spiral bevel type. Speed, 1000 R. P. M. Belt speed 2480 feet per minute.

PERFORMANCE—Average amount of plowing which can be done in 10 hours—6 acres. Turning circle, 21 feet.

mix the kerosene and flushing oil, then remove crankcase plug for the last time to drain out the flushing oil and kerosene. After replacing the plug refill with fresh oil until it runs slowly from the upper pet cock.

Do not make the mistake of putting too much grease in the differential housing. The housing should not be more than one-third full. If a fluid grease is used the level should be approximately one and one-half inches below the oil hole. The oil plug should be removed about every 1,000 miles and more grease added if necessary. While the chart presented specifies that the fan be lubricated with grease every 200 miles, this applies only to cars having fans equipped with grease cups. The new style magazine oiler fans should be lubricated by unscrewing the oil plug and filling the hub, which is hollow, to form a reservoir or magazine, with a heavy but fluid oil.

Fordson Tractor Ignition System.—The uneven sputter and bang of the exhaust means that one or more cylinders are exploding irregularly or not at all, and that the trouble should be promptly located and overcome. Misfiring, if allowed to continue, will in time injure the motor and entire mechanism. A good driver will be satisfied only with a soft, steady purr from the exhaust. If anything goes wrong, stop and fix it immediately if possible.

If misfiring occurs when running at high speeds, inspect the commutator. The surface of the circle around which the roller travels should be clean and smooth, so that the roller makes a perfect contact at all points. If the roller fails to make a good contact on any one of the four contact points, its corresponding cylinder will not fire. Clean these surfaces, if dirty. In case the fibre, contact points and roller of the commutator are badly

worn, the most satisfactory remedy is to replace them with new parts. The spring should be strong enough to make a firm contact between the roller points even if they are worn or dirty.

It is a well-known fact that in cold weather even the best grades of lubricating oil are apt to congeal to some extent. If this occurs in the commutator, it is possible that it may prevent the roller from making perfect contact with the segments embedded in the fibre. This, of course, makes difficult starting, as the roller arm spring is not stiff enough to brush away the film of oil which naturally forms on the contact segment surface. To overcome this, we recommend a mixture of 25 per cent kerosene with the commutator lubrication oil, which will thin it sufficiently to prevent congealing or freezing. Probably in starting the motor in cold weather only one or two cylinders will fire for the first minute or so, which indicates that the timer is in the condition described above and as a consequence a perfect contact is not being made on each of the four segments.

When the vibrators are not properly adjusted more current is required to make and break the contact between the points. As a result, at cranking you do not get a spark between the spark plug points. Do not allow the contact points to become "ragged," otherwise they are apt to stick and cause unnecessary difficulty in starting and when running they may cause an occasional "miss" in the motor.

The essentials of the tractor ignition system are shown at Fig. 180 and in general principles and arrangement of units it is very much the same as that of the Ford Model T car and truck engine.

It is not hard to locate which cylinder is at fault if

the Fordson tractor motor misfires. This is done by manipulating the vibrators on the spark coils. Open the throttle until the motor is running at a good speed, and

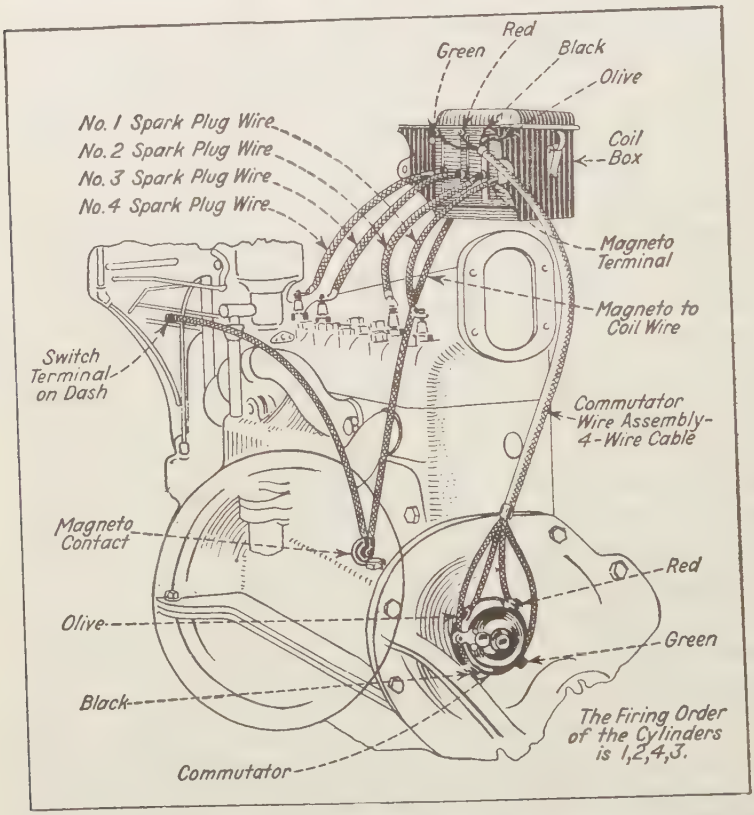


Fig. 180—Ignition System of Fordson Tractor Showing Commutator and Ignition Coil Box Location.

then hold down the two outside vibrators (No. 1 and No. 4) with the fingers so they cannot buzz. This cuts out the two corresponding cylinders (No. 1 and No. 4), leaving only No. 2 and No. 3 running. If they explode regu-

larly it is obvious the trouble is either in No. 1 or No. 4. Relieve No. 4 and hold down No. 2 and No. 3, and also No. 1; if No. 4 cylinder explodes evenly it is evident the misfiring is in No. 1. In this manner all of the cylinders in turn can be tested until the trouble is located. Examine both the spark plugs and the vibrator of the missing cylinder.

Late Type Fordson Vaporizer.—With the type of vaporizer shown at Fig. 181 the control of heat is accomplished by means of the heat control valve, the intake manifold floater and the heat booster. When starting the motor on gasoline or operating it on kerosene the heat control valve should be turned to "Ker." If the motor is operated on gasoline the heat control valve should be turned to "Gas" after the motor becomes warmed up. The intake manifold floater and heat booster operate automatically in connection with the opening and closing of the throttle. At low engine speeds the throttle being only slightly open a high vacuum is created and but a small amount of mixture passes through the carburetor. At low speeds the intake manifold floater is in the idling position, forcing the mixture down into the generating pocket which is heated by the exhaust gases. At the same time the high vacuum draws heat through the small holes in the heat booster and the mixture is completely vaporized. At higher engine speeds less heat is required to vaporize the mixture and as the speed of the engine is increased by opening the throttle the intake manifold floater is gradually raised to the high speed position by the increased volume of mixture, thus lessening the contact of the mixture with the heated generating pocket and at the same time the decreased vacuum draws less heat through the heat booster. The automatic action of the

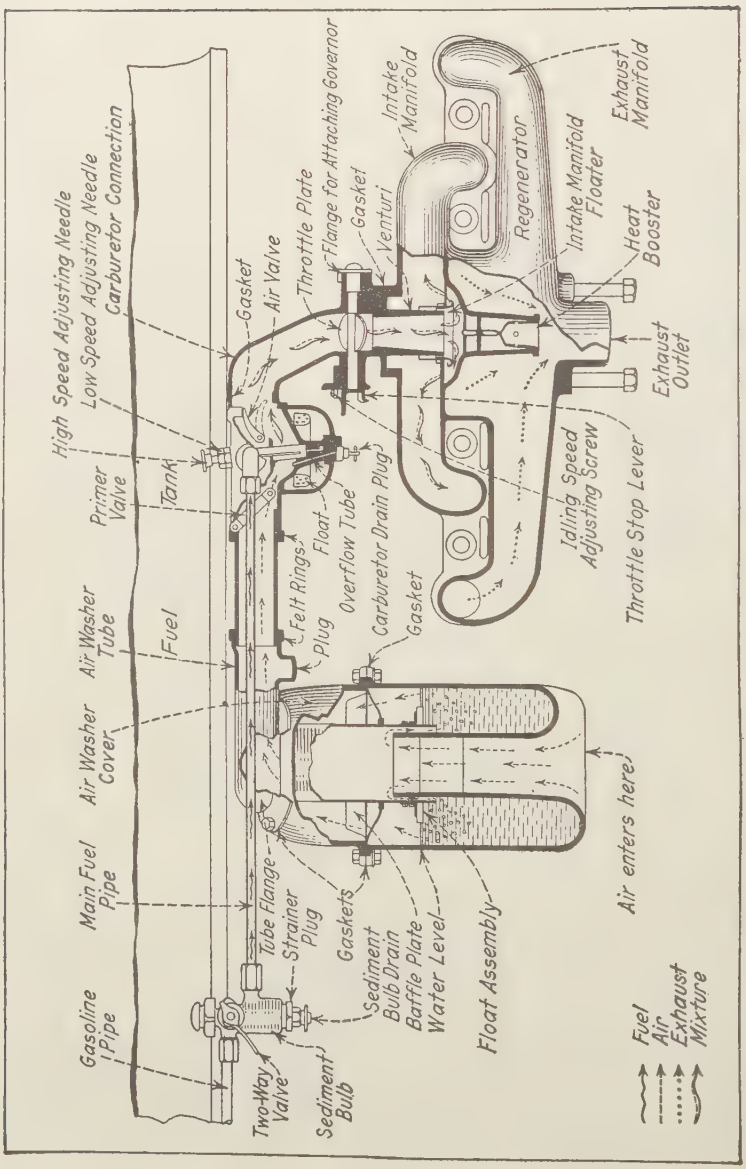


Fig. 181—Sectional View Depicting Construction of the Two Adjustment Type Fordson Tractor Vaporizer and Important Parts of the Fuel and Carburetion System.

intake manifold floater and the heat booster gives the correct heat for complete vaporization of the fuel at all engine speeds.

The type of vaporizer shown at Fig. 181 is adjusted by means of the high and low speed adjusting needles. Turn two-way valve to "Gas" and if carburetor bowl is filled with kerosene, drain the kerosene off by means of the carburetor drain plug, as adjustment should be made while using gasoline. Loosen high speed lock nut and turn high speed adjusting needle down until it seats (do not force it against the seat), then turn it back one and one-quarter turns. Adjust the low speed adjusting needle in the same way.

Start the engine (using the choke) and let it run until warmed up. Turn the kerosene on and with the throttle open (do not race the engine) turn the high speed adjusting needle down until the motor begins to misfire, then turn the needle back until the engine operates smoothly. Tighten the high speed lock nut. Close the throttle and adjust the low speed adjusting needle in the same way as the high speed needle was adjusted. With high and low speed adjusting needles correctly adjusted, the carburetor will function properly at all engine speeds.

The vaporizer illustrated in Fig. 122, page 339, has but one adjustment—the fuel needle valve.

The usual method of regulating is to start the motor on gasoline and run it for three or five minutes—keeping the shunt valve on the "ON" position. Turn down the needle valve lightly to its seat, then open it one and one-half turns. Turn the two-way valve to kerosene, leaving shunt valve on the "ON" position, retard the spark lever to about the fourth notch and open the throttle until the motor is running at a good speed. The flow of kerosene

should then be cut off by screwing the needle valve down to the right until the motor begins to misfire, then gradually increase the kerosene supply by opening the needle valve until the motor reaches its highest speed and no smoke comes from the exhaust. (This usually takes half a turn.) After the best adjustment has been found the driver should observe the angle of the adjusting rod on the dash. In cold weather it will probably be found necessary to turn the adjusting rod one-quarter turn to the left, particularly before the motor has been thoroughly warmed.

Should dirt get into the fuel it may clog the spraying nozzle, causing the motor to misfire and slow down. By opening the adjusting needle half a turn and opening the throttle quickly two or three times, the dirt may be drawn through, after which the needle should be turned to its original position. If this does not remove the dirt, shut off the fuel at the sediment bulb, remove the fuel bowl from the carburetor and clean out the spraying nozzle by means of a fine wire. The nozzle can be taken out and cleaned by removing the plug which screws into the float chamber just under the nozzle.

Fordson Tractor Brake.—A number of readers of our earlier editions have suggested that more details be given about the tractor brake, so its relation to the clutch and flywheel and how it is operated from the clutch pedal is clearly shown at Fig. 182, and if this illustration is studied in connection with that shown on page 431, Fig. 167, and the following description carefully read, the operating principles should be apparent to all.

The brake shaft extends through the hollow reverse idler shaft. Three of the brake plates (one rotating plate between two stationary plates) are placed in front of the

reverse idler gear, and two brake plates and the brake hub (the rotating plate between the stationary plate and hub) are placed in back of the reverse idler gear, the stationary plate being placed next to the gear.

The brake spring, retainer nut and cotter are placed on the rear end of the brake shaft. When the clutch pedal

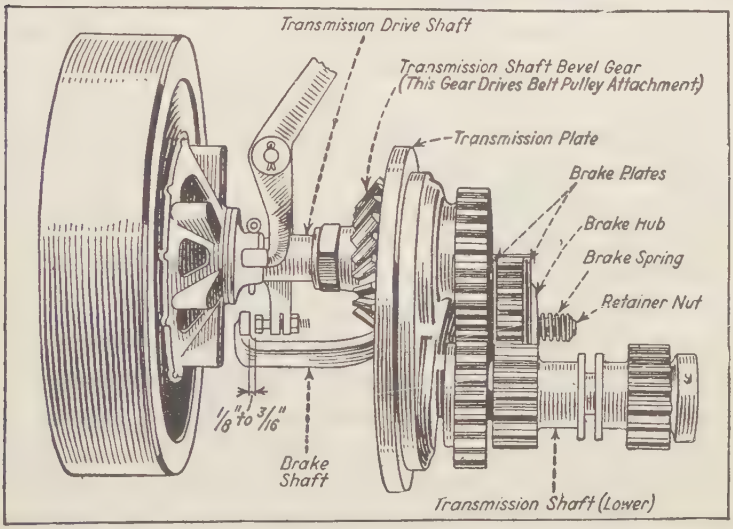


Fig. 182—Diagram Showing Location and Method of Operation of Fordson Tractor Brake and Its Relation to Transmission Gearing.

is depressed beyond a point where the clutch is released, the brake adjusting screw at the lower end of the clutch lever pushes the brake shaft forward, compressing the brake plates and gripping the idler gear. The brake spring is under compression at all times but as it fits against a shoulder on the brake shaft, it exerts no pressure on the brake plates until the clutch pedal is pushed down.

Ordinarily, any adjustment required can be made by

removing the foot bracket at the side of the transmission housing and turning the brake adjusting screw. The gap between the head of the adjusting screw and brake shaft should be between ⅛ in. and 3/16 in. It should seldom be necessary to replace the brake plates or increase the tension of the brake spring, but should this become necessary, separate the rear half of the tractor from the motor and remove the transmission plate as previously described. The plates can be replaced or spring tension increased as required. The factory advises caution in reassembling the brake to see that the head of the adjusting screw points toward the front of the tractor and that the foot on the front end of the brake shaft points upward where the adjusting screw can strike it.

Removing and Adjusting Tractor Clutch.— More information has also been requested about removing and adjusting the clutch, especially as to how the two halves of the casing can be held together after the bolts are removed so the spring tension can be relieved gradually in taking the clutch apart and brought together compressing the springs, to permit the bolts being inserted for reassembling. The means of doing this are very clearly shown in illustrations at Fig. 183. The clutch parts in their relative assembling position are clearly outlined at "A." The view at "B" shows the clutch in position on the drive shaft, the repairman tightening it to the shaft with a hexagonal nut. The method of drawing the clutch parts together with a bolt is shown at "C." The use of two C clamps to draw the clutch members together is depicted at "D". Obviously, the use of clamps in this manner would prevent the clutch from coming apart too rapidly when disassembling after the bolts had been removed. The view at "E" shows the position of the

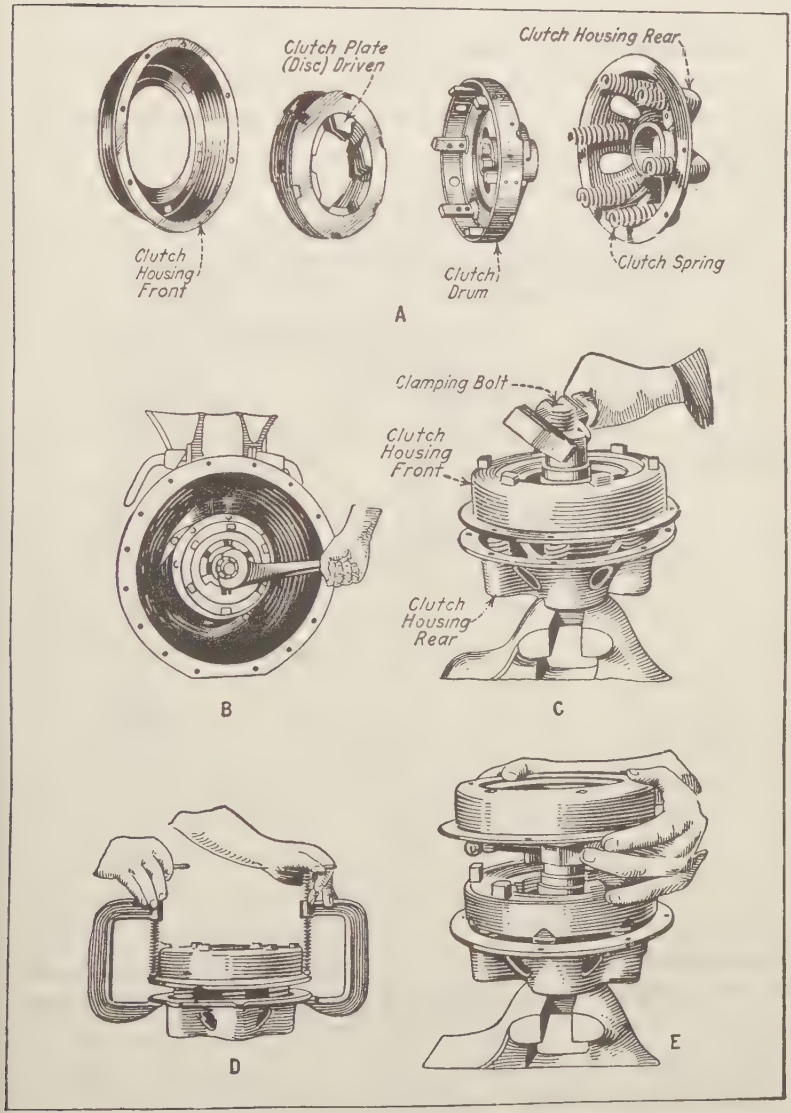


Fig. 183—Suggestions for Holding Fordson Tractor Clutch Parts Together when Dismantling or Assembling Clutch.

clutch during assembly. Full instructions to supplement these are given on pages 362 and 363.

Removing New Style Cowl Tank.—The new design cowl tank is shown at Fig. 184, which shows the method of

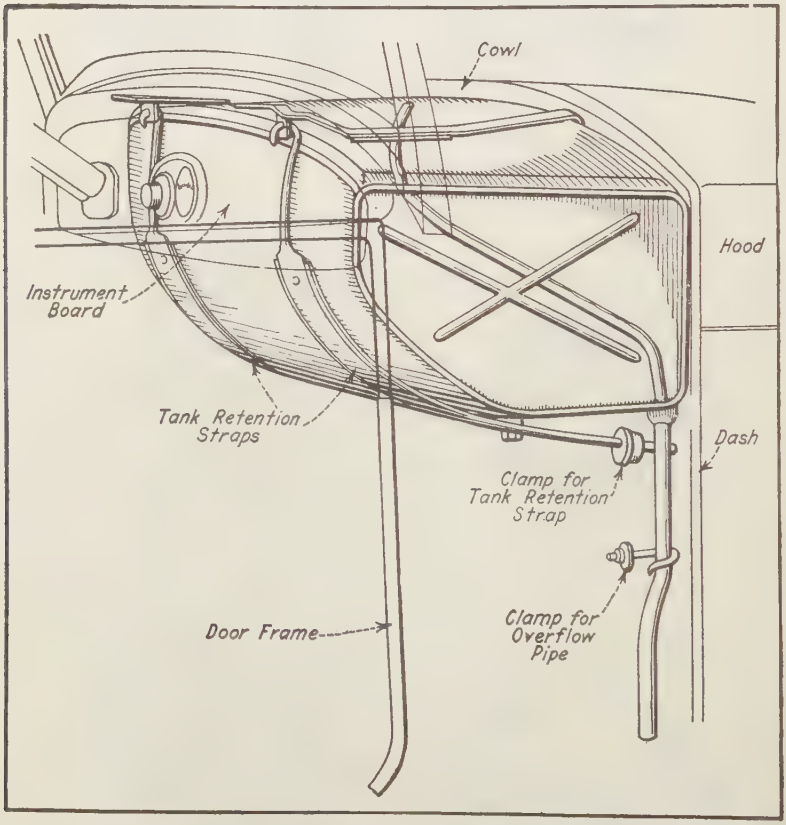


Fig. 184—Diagram Showing Method of Supporting Cowl Tank in Late Model Ford Cars.

supporting it in the cowl. The new fuel tank is placed underneath the cowl, between the instrument board and the dash. This location brings the tank almost directly

over the carburetor and insures a positive supply of gasoline to the mixing device, even when climbing the steepest gradients.

To remove the new tank the first step is to close the shut-off cock on the sediment bulb, then the fuel pipe packing nut at the sediment bulb feed elbow is backed off and the supply pipe is withdrawn from the elbow. The gasoline tank should be drained. A quick method of draining the tank is to place a funnel, which has been inserted in the end of a 5 or 6-foot length of rubber hose, under the sediment bulb connection and having the discharge end of the hose in some suitable container, preferably a ten-gallon tank or a five-gallon gasoline tank may be used, if another one is at hand to catch any surplus that may drain out of the tank.

After the gasoline has been drained from the tank the nut should be loosened from the clamp for the overflow pipe. This overflow pipe can then be withdrawn from the connection on the gasoline tank. The carburetor adjusting rod is then drawn back through the dash. The next step is to release the two gasoline tank retention strap nuts and lift off the washers. The nuts at the ends of the screws, which hold the ignition switch in place are held while the screws are loosened, to permit withdrawing the ignition switch from the instrument board.

In order to prevent any possibility of a spark occurring if the gasoline tank should touch the terminals of the wires on the switch when the tank is withdrawn and there is danger of such a spark setting fire to any gasoline fumes which may be present, it will be found a wise precaution to undo the battery wire and insert a small piece of rubber tubing over the end of the battery wire terminal or to cover the battery wire terminal with tape.

The next step is to lift out the mat and the floor boards, then the transmission cover door screws are removed and the adjusting nuts on the end of the reverse and brake pedal shafts are backed up. After the reverse and brake pedals have been loosened the transmission cover door should be replaced temporarily to prevent any parts or

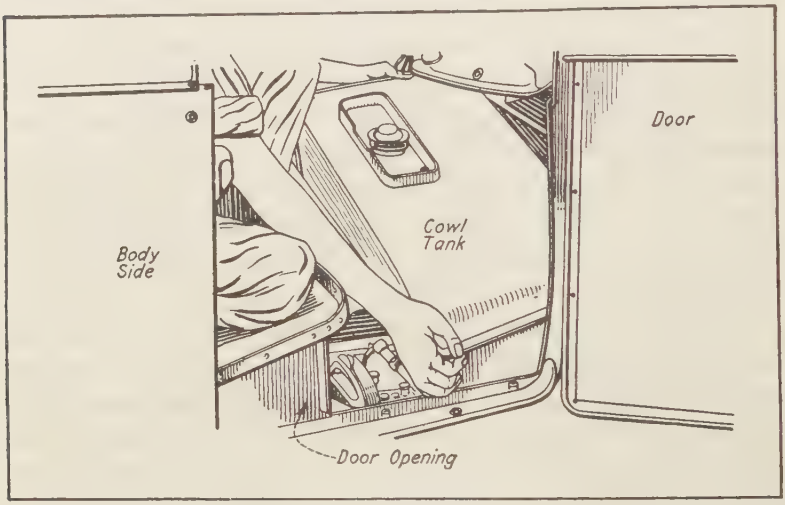


Fig. 185—How Cowl Tank May be Removed from Ford Body.

foreign matter getting in the transmission and one retention screw will be found adequate to hold that door in position. The gasoline tank straps are then pulled through the dash into the body and are bent straight down. As the other end of the straps are hooked into brackets which are attached to the top of the cowl, if the straps are unhooked from these brackets they may be withdrawn and will be out of the way. The brake and reverse pedals are then forced forward as far as they will go, as there will be plenty of clearance to drop the tank.

Move the tank back and forth until the sediment bulb connection clears an opening in the dash and when the connection has cleared this opening, the tank may be lifted out as shown at Fig. 185 and may be removed from the car entirely by passing it through the opening left by swinging the door as far as it will open.

To install the tank a reverse process is followed. The first step is to insert the sediment bulb connection through the opening in the dash. Then the two tank straps are hooked into the brackets at the top of the cowl and the straps are opened so they will fit closely against the tank and the threaded ends of the straps are passed through the holes in the dash. The spacer washer and lug washer are then put on and the nuts on the end of the straps are run down tightly so that the straps hug the tank closely and keep it in place. The overflow pipe is then lined up with the sediment bulb. The sediment bulb is screwed into the sediment bulb connection and the gasoline supply pipe is put into the sediment bulb elbow and the packing nut screwed in place.

The carburetor adjusting rod is then passed through the instrument board and the dash and placed in the proper position in the carburetor needle valve. The ignition switch is replaced on the instrument board, then the transmission cover door is taken off and the brake and reverse pedals are adjusted, after which the transmission cover door is permanently installed by putting in the six screws which hold it to the transmission cover. The floor boards and mat are replaced and the battery wire is connected to the battery wire screw on the terminal block, after the rubber tubing or tape has been removed.

Installing New Type Transmission Cover.—The new type Ford transmission cover has been designed with an extension at the top of the cover, which is intended to give added support against the crank case, and steel shims are placed between this extension and the cylinder block to insure accurate alignment of the universal ball cap.

Whenever the engine of the new Ford is overhauled or repaired, if the operation calls for the removal of the transmission case or crank case, it is very important when installing the transmission cover to make sure that the universal ball cap bearing lines up accurately on the drive plate shaft. To make sure that these parts will be in exact alignment, the crank case and transmission cover are installed as shown at A, Fig. 186, which shows the top transmission cover and cylinder bolts. These are inserted half way into the cylinder block and the end of the ball cap is checked by loosening two of the ball cap retention screws which allows the movement of the ball cap back and forth on the shaft. If the cap moves freely the alignment of the crank case and cylinder block is correct and the two transmission cover retention bolts can be screwed in place in the cylinder block. If the ball cap does not move freely on the drive plate shaft a pinch bar or large screwdriver can be inserted between the cylinder block and the transmission cover, at a point back of the extension, and the transmission is pried back until the ball cap moves freely on the shaft.

This will result in a small opening being left between the extension on the transmission cover and the corresponding seating on the cylinder block casting. A sufficient number of shims should be inserted to completely fill the space between these parts. When enough shims have been supplied to keep the pieces in their proper

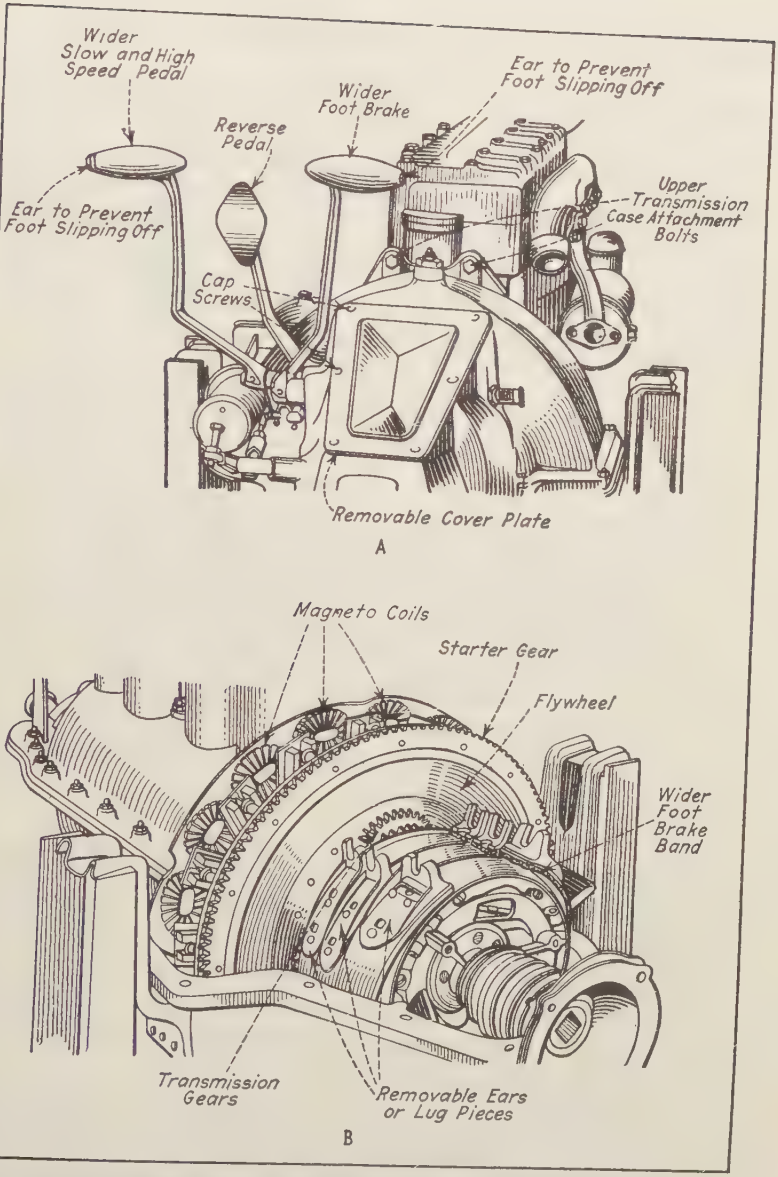


Fig. 186—How New Style Ford Transmission Case is Attached to Cylinder Block. A—View Showing Extension on Upper Case and Method of Attachment to Cylinder Block. B—Transmission with Upper Case Removed, Showing Removable Ears on Brake Bands and Wider Bands.

relative positions, the pry bar can be removed and the transmission cover bolts screwed down tightly.

When performing any repair operation that calls only for the removal of the transmission cover on the new type Fords it is important that care be exercised when removing the cover to note the exact number of shims which were removed and to replace exactly the same number. Ordinarily if this is done it will not be necessary to adjust the parts.

The new transmission and foot brake bands with the removable ears or lug pieces are clearly shown in the illustration at B, Fig. 186. In addition to widening the brake bands to secure longer life, hardened steel wear pieces or shoes have been fitted over each of the six lugs inside of the transmission brake drum, in order to prevent any tendency to cutting the lugs by the edges of the clutch discs. These shoes may be readily withdrawn if worn by withdrawing them from the brake drum lugs with a pair of pliers and the new shoes may be installed for repair purposes by slipping them in place over the lugs and tapping them down into place with a small hammer.

Removing and Installing New Lined Brake.—Considerable trouble was experienced with the Ford car models that had the cast iron brake shoes and the small brake drums and it is not always possible to secure adequate or positive braking effect when the hand lever is applied, so a larger brake is now used as may be readily ascertained by inspection of Fig. 187.

The new hub brake shoe, as shown at A, has been increased from $7\frac{15}{16}$″ in diameter to $10\frac{15}{16}$″ in diameter and the width of the shoe has been augmented from 1″ to 1½″. In addition the hub brake shoes are now of pressed

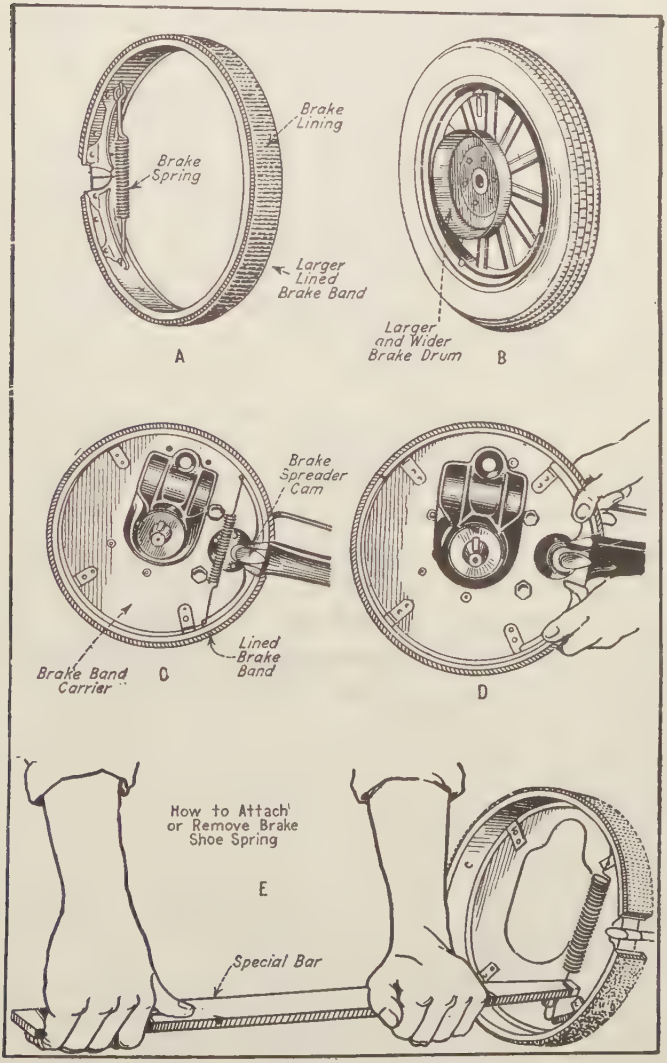


Fig. 187—Views Showing Improved and Enlarged Ford Rear Wheel Brake. A—Lined Pressed Steel Band and Spring. B—Wheel and Brake Drum. C—How Brake Shoe or Band is Supported. D—Method of Removing Brake Shoe. E—Special Tool to Install or Remove Brake Shoe Spring.

steel, which is much more flexible than cast iron formerly employed, and it will not break. The pressed steel shoes are covered with a heavy lining of asbestos, which takes the wear, makes braking smoother and more positive because it eliminates all metal to metal contact that formerly obtained between the brake shoe and the brake drum. The hub brake drum, which is shown at B, has been increased from 8″ in diameter to 11″ in diameter and the width has been made proportionately greater in order to receive the wider brake band.

The brake shoe is assembled to the axle housing or brake band carrier plate by the use of four steel clips, which are riveted to the plate and which are clearly indicated at C. A heavy coil spring, which is shown at A and C, holds the ends of the shoe firmly against the brake spreader cam. To remove the shoe brake, it is first necessary to remove the rear wheel in the customary manner, as has been previously described. As the new type spring is much larger and has a stronger tension than the old type springs, a simple special tool, such as shown at E, may be used to make the removal and installation of the spring easier. After the spring has been removed the brake shoe may be easily lifted from the brake band carrier, as shown at D.

To install the new brake shoe it should first be positioned on the brake band carrier or axle brake housing plate, inserting the flange on the edge of the shoe behind the four steel clips on the housing plate. The brake shoe should be so positioned that the brake spreader or hub brake cam can be entered between the ends of the brake shoe. The brake shoe spring is installed by placing the loop at one end over the lug at the upper inner periphery

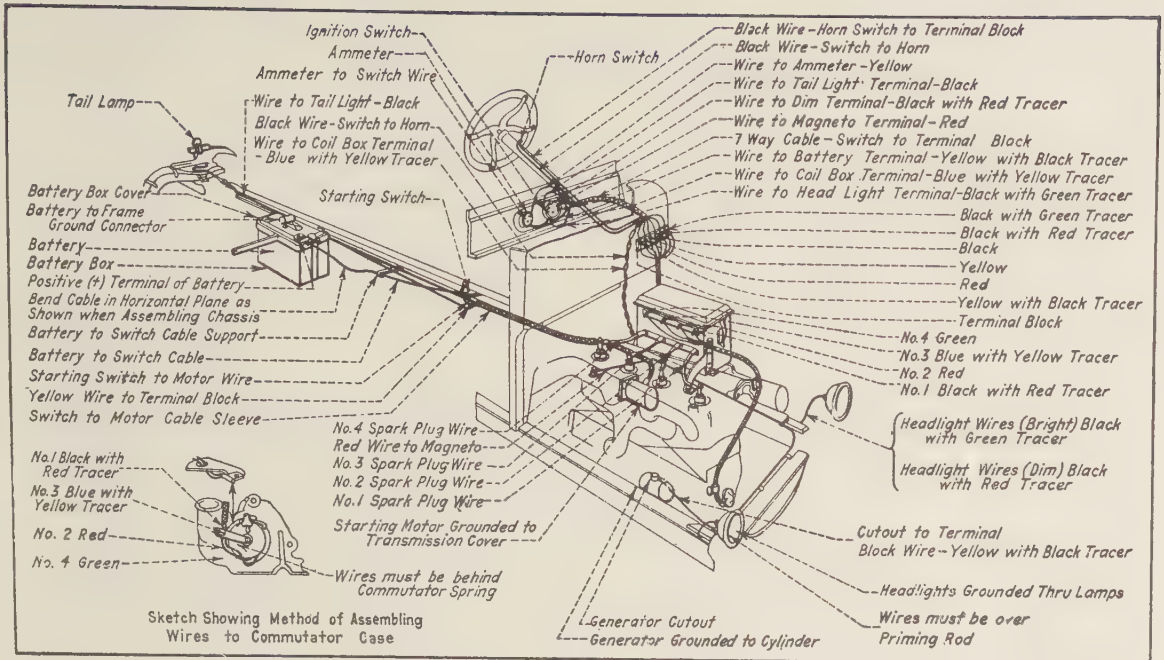

Ignition Switch
Ammeter
Ammeter to Switch Wire
Tail Lamp
Wire to Tail Light - Black
Black Wire - Switch to Horn
Wire to Coil Box Terminal - Blue with Yellow Tracer
Horn Switch
Starting Switch
Battery Box Cover
Battery to Frame Ground Connector
Battery
Battery Box
Positive (+) Terminal of Battery
Bend Cable in Horizontal Plane as Shown when Assembling Chassis
Battery to Switch Cable Support
Battery to Switch Cable
Starting Switch to Motor Wire
Yellow Wire to Terminal Block
Switch to Motor Cable Sleeve
No. 4 Spark Plug Wire
Red Wire to Magneto
No. 3 Spark Plug Wire
No. 2 Spark Plug Wire
No. 1 Spark Plug Wire
Starting Motor Grounded to Transmission Cover
No. 1 Black with Red Tracer
No. 3 Blue with Yellow Tracer
No. 2 Red
No. 4 Green
Wires must be behind Commutator Spring
Sketch Showing Method of Assembling Wires to Commutator Case
Black Wire - Horn Switch to Terminal Block
Black Wire - Switch to Horn
Wire to Ammeter - Yellow
Wire to Tail Light Terminal - Black
Wire to Dim Terminal - Black with Red Tracer
Wire to Magneto Terminal - Red
7 Way Cable - Switch to Terminal Block
Wire to Battery Terminal - Yellow with Black Tracer
Wire to Coil Box Terminal - Blue with Yellow Tracer
Wire to Head Light Terminal - Black with Green Tracer
Black with Green Tracer
Black with Red Tracer
Black
Yellow
Red
Yellow with Black Tracer
Terminal Block
No. 4 Green
No. 3 Blue with Yellow Tracer
No. 2 Red
No. 1 Black with Red Tracer
Headlight Wires (Bright) Black with Green Tracer
Headlight Wires (Dim) Black with Red Tracer
Cutout to Terminal Block Wire - Yellow with Black Tracer
Headlights Grounded Thru Lamps
Wires must be over Priming Rod
Generator Cutout
Generator Grounded to Cylinder

Fig. 188—Wiring Diagram, Showing Lighting Starting, Ignition and Horn Circuits on Late Model Ford Cars.

of the brake shoe and then hooking the other end over the lug on the lower inner periphery of the brake shoe. The operation is outlined clearly enough in the illustrations, so further description seems unnecessary.

Also consult Index for Model A Car on page 573

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MODEL A FORD SUPPLEMENT

COMPLETELY ILLUSTRATED
DESCRIPTION AND
INSTRUCTIONS

FOR CARE AND MAINTENANCE OF
MODEL A FORD AUTOMOBILES
AND MODEL A TRUCKS

CHAPTER XI

DESCRIPTION OF THE FORD MODEL "A" CARS

In the preceding chapters of this book, reference is frequently made to Ford parts and illustrations are presented to supplement the descriptive matter. For a number of years, the makers concentrated on one model of chassis, known as the Model T, and 15,000,000 of these cars were built All of the material previously presented applies to the Model T car. Inasmuch as there is a great interest in the mechanical features of the new Model A Ford Car, it is believed that this description will be of value in this revised and enlarged treatise.

The new Ford is a car that conforms more to standard practice than the Model T, and the well-known features of that car, the flywheel magneto and the planetary transmission, are not found in the new model, which has a standard gear shift and a conventional electrical system. The body lines of the new cars are a marked improvement over those found in the old car. The side view of the Tudor sedan, a very popular model, shown at Fig. 1, is typical of the graceful proportions of the entire line. The front view of the phaeton, shown at Fig. 2, shows the new radiator design and lamp hook-up.

The Model A has a four-cylinder engine of 3⅞ in. bore and 4¼ in. stroke, which gives a piston displacement of 200.5 cu. in. The engine is oiled by the circulating splash system, the pump delivering into the valve

chamber, from which the oil flows by gravity to each of the main bearings. Connecting rod heads are provided with dippers which splash oil from troughs in the lower part of the crankcase to all of the other parts of the engine requiring lubrication. The transmission, which is of the regular sliding pinion type, has gears made of

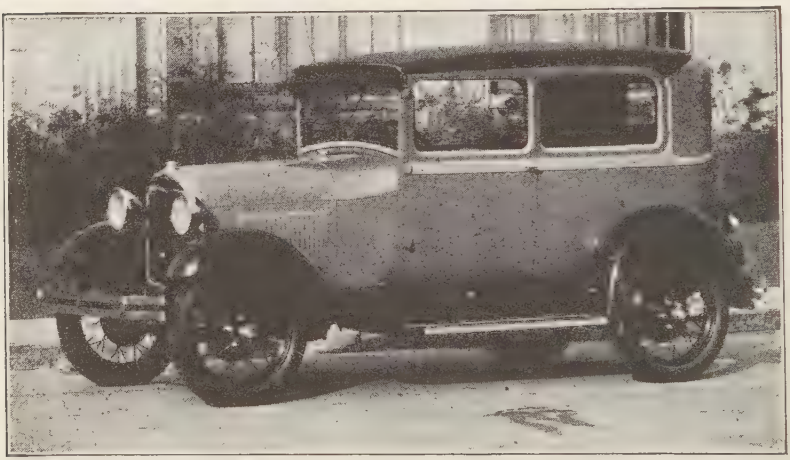

Fig. 1.—Side View of Ford Model A Tudor Sedan Showing Graceful Body Lines and Modern Appearance.

chrome steel. Four-point suspension is used for the engine, the rear support brackets on the flywheel housing bolting directly to the frame side members, thus forming an additional cross-member, while at the front the engine is supported on a rearward extension, in the form of an inverted channel, of the frame front cross-member. As has been mentioned, the clutch and transmission are similar in design to the corresponding units used in the Lincoln, the transmission being of the three-speed, standard-shift type, and the clutch a multiple disk, dry design.

Drive to the rear axle is by an inclosed propeller shaft with ball-joint at the forward end, to the propeller-shaft-tube member of which the diagonal radius rods from the rear axle housing are secured. The rear axle is of three-quarter floating type. Both the generator and the starting motor are located on the left side of the engine (looked at from the rear), the former being driven by the V-type fan belt, while the latter drives to the flywheel. The attention of the reader is directed to the

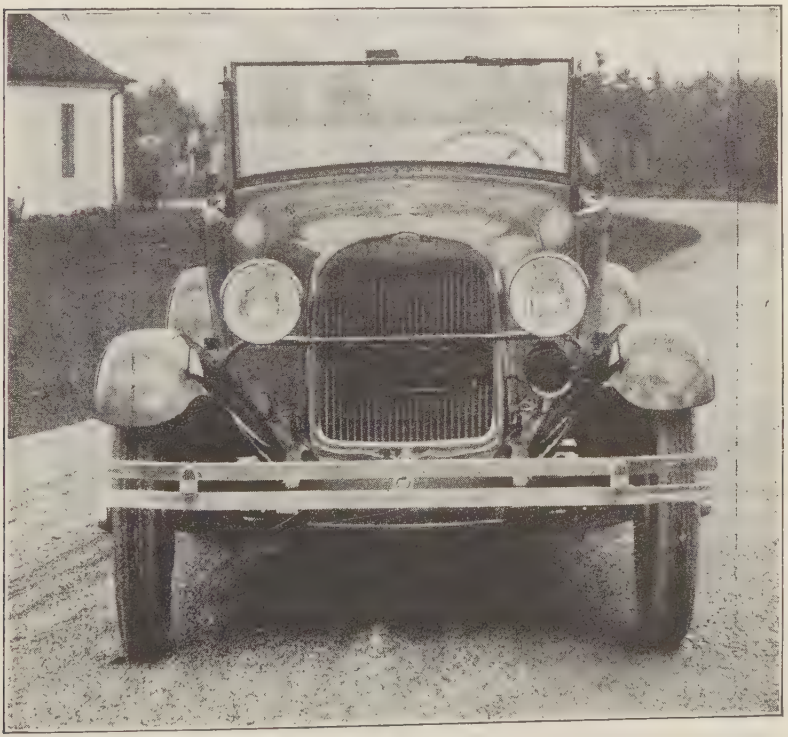

Fig. 2.—Front View of Ford Model A Phaeton Showing Radiator Design, Full Crown Fenders and Lamp Installation.

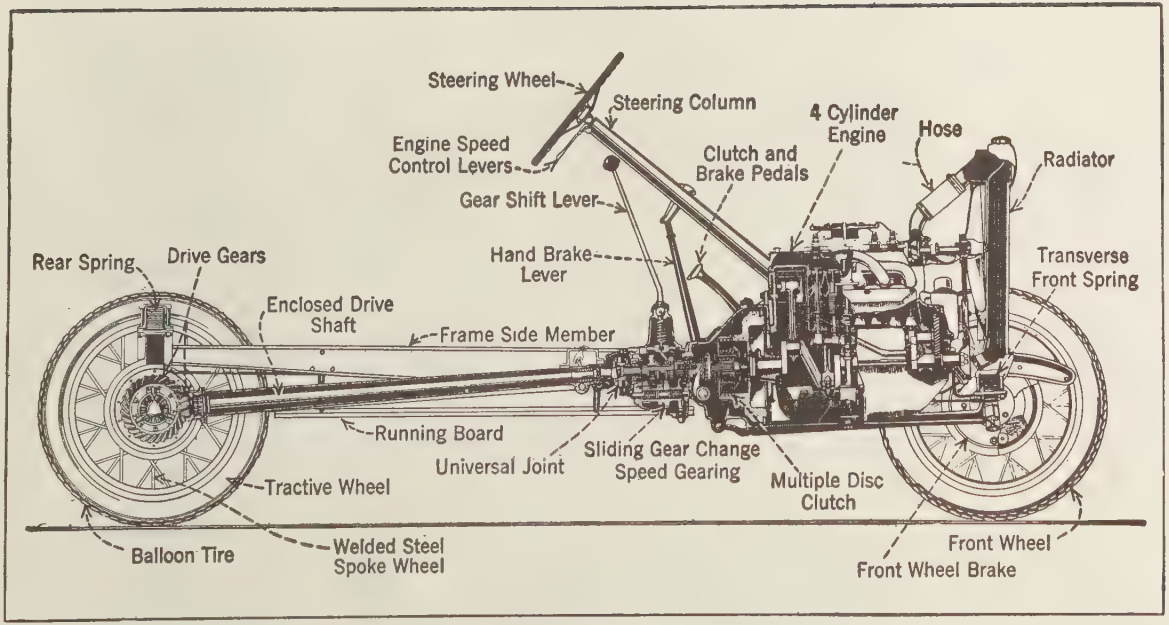

Fig. 3.—Sectional View of Ford Model A Chassis Showing Power Plant in Part Section, also Clutch, Three Speed Sliding Gearset and Shaft Drive to Rear Axle.

sectional view of the chassis shown at Fig. 3, as this clearly shows the main details of the chassis. As can be clearly seen, three cross-members are used in the frame. These are all of the gusseted type, the front member having the form of a double channel, while the others are of the regular channel type. In contrast to statements recently made in various automotive publications, the frame members are riveted together and not welded. The cross-members, of course, are supplemented by the rear engine supports, which virtually form an additional cross-member. There is also a pressed steel member tying together the rear bumpers. An outward bulge of the rear part of the frame is also noticeable.

Radius rods for the front axle have also been redesigned. Like those for the rear axle, they are of the tubular type with an elliptic cross-section, and they connect at the rear end to the bottom of the transmission case through a ball joint. At the front end, they connect to the axle by means of yoke-and-pin joints, the pins passing vertically through eyes in the yoke and the front axle. Wire wheels of the same type as used on the last Model T series are standard equipment, a spare wheel being included. These wheels take 29 x 4.50 in. balloon tires.

The Model A Ford Bodies.— Bodies are of composite construction. The body and pillars, and the roof side rails are of wood, sheet-steel-clad, and are covered with sheet-steel panels. On the closed models complete body side panels are built up and flash-welded onto the rear body panel. Tops are fabric-covered. Cowls are made in three pieces, the top part being formed by the gasoline tank, to which the side panels are flash welded. Fenders

are full-crowned, belt lines are higher, and the wheelbase is longer.

A new instrument panel is adopted. This is roughly of diamond-shape, with the dash gasoline gage, reading in quarters of tank capacity, at the top, the speedometer at the bottom, the ammeter at the right, the ignition lock at the left, and the instrument board lamp in the center. The ignition lock is of the Electrolock type, grounding the distributor, the connecting cable being enclosed in a metal conduit. Spark and throttle control levers are still mounted on the steering column below the wheel, but the former quadrants have been eliminated, and a foot accelerator is provided. Above the wheel on the steering column is mounted the light control lever. Double-filament, double-contact bulbs are used in the bullet-type headlamps.

A combination tail and stop light is standard equipment, as are also Houdaille shock absorbers, front bumpers and rear bumperettes. The latter attach to both the frame and the body and are curved to carry out body lines. They, as well as the front bumpers, are assembled on the cars before the body is put on, but are easily removable. Additional items of equipment are an automatic windshield wiper, a swinging type one-piece windshield with ventilating ports in the top of the cowl exposed when opening the windshield, a speedometer, which is driven from the front end of the propeller shaft, and a Sparton horn which is mounted between the radiator shell and the left fender below the headlamp. The crank handle is removable, whereas in the Model T it could not be removed. The running boards are of steel construction, rubber-covered, with aluminum bindings and concealed screws.

Interior finish of the cars is also decidedly improved. On the open models and the cabriolet, unpleated brown imitation leather is used for the upholstery, the seat cushions having a single pleat running lengthwise of the cushion, about two-thirds of the way forward. In the closed cars cloth upholstery is used, with doors and side walls trimmed in the same materials, the doors being fitted with pockets also made of pleated upholstery material. Door controls are of the remote type, operating by lifting the lever, rather than by turning it. Windows are crank-operated, and door snap locks are provided inside the closed cars. On the cabriolet a regulation roll-up type of rear curtain is provided. A choice of four colors is being offered, namely, Niagara blue, Arabian sand, Dawn gray, and Gunmetal blue. The belt and reveals are in all cases in contrasting colors and the bodies are attractively striped. All cars are finished in pyroxylin lacquer. The fenders are of the full-crowned type and harmonize with the body lines.

Seat cushions are deeper and softer than those of the Model T. Door handles and window lifts are nickel-plated. The speedometer, gasoline gauge, a meter and ignition lock are mounted on an instrument panel of satin-finish nickel and are illuminated by a lamp mounted in the center. The headlamps and radiator shell are nickel-plated on all exposed surfaces. The closed cars have the cadet type of sun visor and a crown roof. Unusually narrow front pillars, together with steel body construction, assure clear vision without impairing body strength.

As will be seen in the mechanical descriptions to follow, the car should be quiet. The body design works to that end, and the very flexible spring construction, work-

ing in conjunction with hydraulic shock absorbers, minimizes road shocks, thus lessening body noises. Care has been exercised in the design of the bodies to prevent squeaks, rattles and drumming sounds.

The Ford Model A Engine.—The engine of the Model A is of brand-new design, and none of its major parts apparently are interchangeable with those of the Model T. For instance, the crankshaft, while still of the three-bearing type, is counterbalanced by machining the first, third, fourth and sixth crankcheeks in cylindrical form.

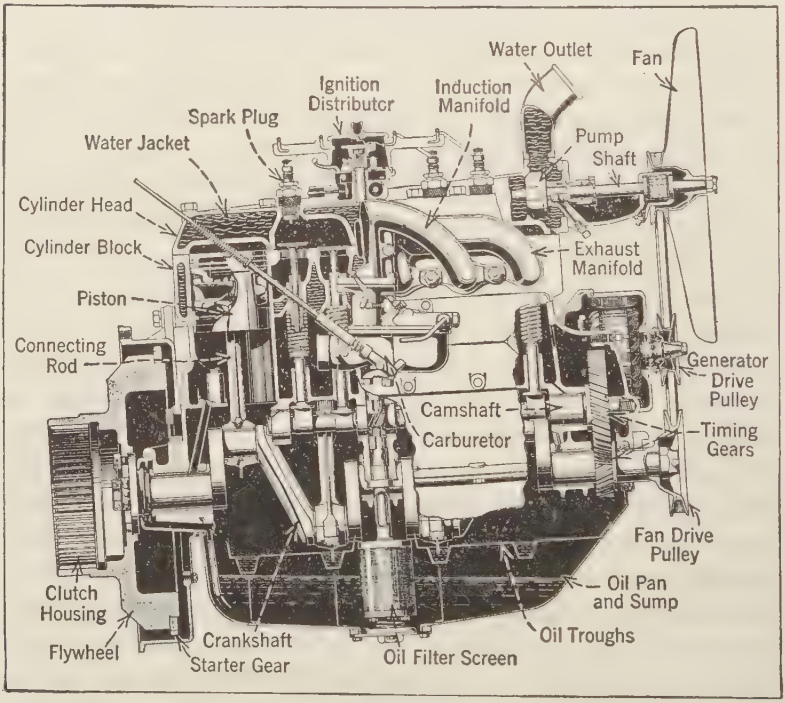

Fig. 4.—Part Sectional View of Ford Model A Engine Showing Design of Important Internal Parts.

Connecting rods are longer and lighter. The sectional view of the engine at Fig. 4 shows the sturdy and simple mechanical construction of the engine very clearly, while the various important components of the power plant shown in illustrations on Fig. 5 serve to make the design of these parts clearer to the reader. The power and accelerating qualities of the engine are remarkable for a low-priced car. In tests in high gear, it is stated that a Model A with a two-door sedan body, with two passengers, is said to have accelerated from 5 to 25 m.p.h. in 8½ seconds, and the maximum road speed varies between 55 and 65 m.p.h. Some road tests have shown a speed in excess of 65 m.p.h., but, quite naturally, the maximum speed which can be attained varies with road conditions, the style of body and the load carried. At 2200 r.p.m. the four-cylinder engine develops 40 hp. on the brake. While the rate of gasoline consumption will vary widely with service conditions, the car will make between 20 and 30 miles per gallon.

A turbulence type of cylinder head is now used and a higher compression ratio provided for. Spark plugs are mounted in the center of the combustion space, and are no longer of the ½ in. type but are ⅞ in. in diameter with 18 threads per inch, as in other makes of cars. Camshafts are of the three-bearing type, but are new in design, and have the drive gear for the vertical accessories shaft machined at the center. Of course, the engine is still of the L-head type. Camshaft drive is by a non-metallic gear, with no idler. The smooth operation and unusual accelerating qualities of the car are due, to a great extent, to the use of aluminum pistons. A three-bearing crankshaft is used, which is provided with circular disks concentric with the shaft in the places of the

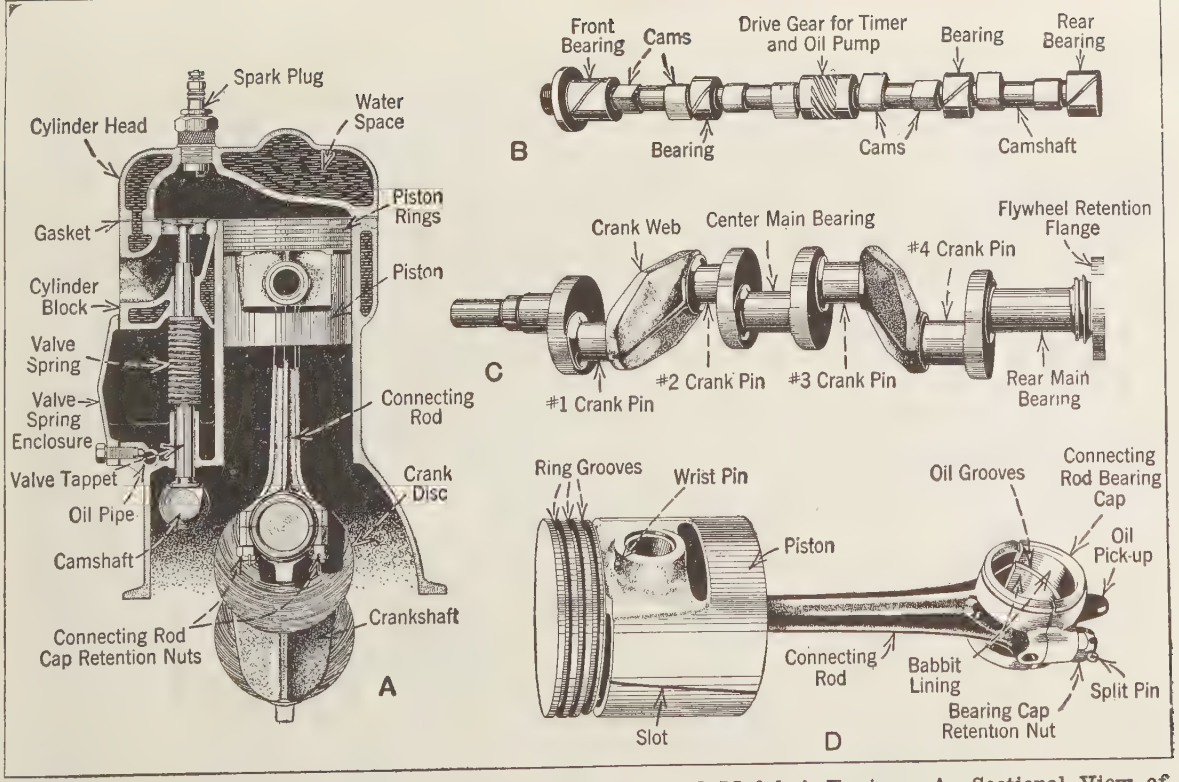

Fig. 5.—Diagrams Showing Important Structural Parts of Ford Model A Engine. A—Sectional View of Cylinder Showing Valve Action, Piston and Connecting Rod and Crankshaft and Their Relation. B—Camshaft Has Large Bearing Area. C—The Crankshaft Has Disc Webs and Is a Three Bearing Type. D—Piston and Connecting Rod Assembly.

usual short arms. This shaft is statically and dynamically balanced, and as a result of the relatively low speed at which the full power is developed, the engine runs with exceptional smoothness. Cam contour and valve clearances have been so worked out that—with non-metallic timing gears—an unusually quiet power-plant results.

Ford Model A Lubrication and Cooling Systems. — Engine lubrication is unique and of distinctive Ford design. The system involves pump circulation, splash and gravity feed. Oil from the pump is delivered to the valve chamber, from which it flows by gravity to the main bearings of the crankshaft. There is an oil dipper on the cap of each connecting rod, which splashes the oil over the bearings and distributes it to all interior parts of the engine. This is shown in the sectional view of the engine on Fig. 6. Lubrication is by force fed to the main bearings, and by splash to all other parts. The oil pump is located at the lowest point of the pressed steel oil pan, a cover below it permitting of its removal without removing the oil pan. Oil is also delivered by pressure to the valve chamber on the right into the sump through a large external pipe.

Cooling is by a centrifugal water pump mounted on the cylinder head and combined with the fan. The cylinder head is provided with a riser to prevent the pocketing of steam in the rear end of the block. Water enters the block centrally at the left side. A two-bladed fan is used, driven by a V-belt, the belt also driving the generator, which is mounted forward on the left side of the engine. Adjustment is by swinging the generator to tighten the fan belt. The details of the cooling system, with all important parts designated, are shown in Fig. 7.

Carburetion and Ignition Systems.—Two of the auxiliaries which have a material influence on engine operation are the carburetion and ignition systems. The fuel

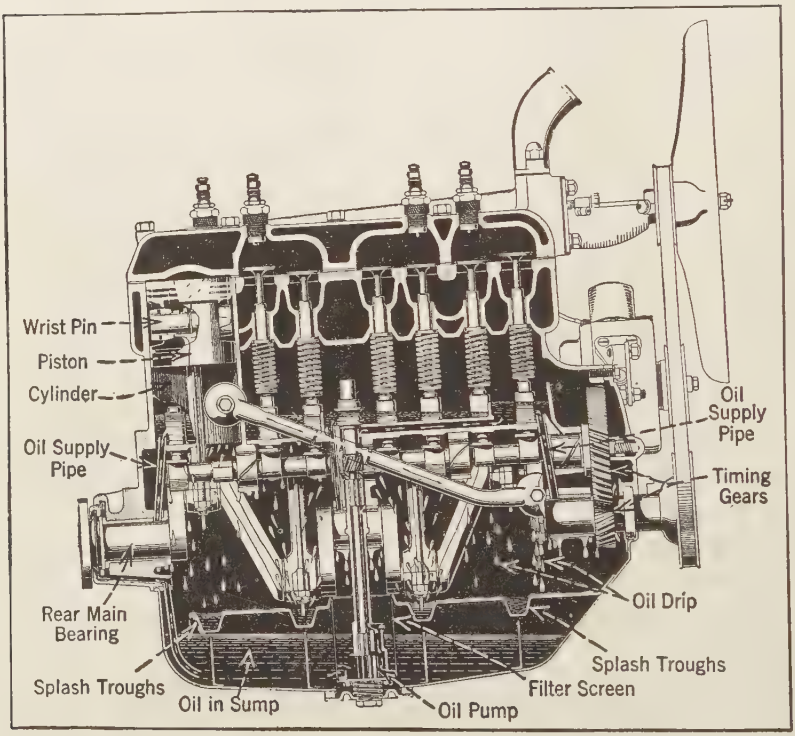

Fig. 6.—Sectional Side Elevation of Ford Model A Motor Showing Oil Pump and Method of Lubrication.

supply and carburetor of the Ford Model A engine are clearly shown at Fig. 8. The fuel tank is part of the body, being placed under the cowl, with the filler cap projecting. It includes a filter screen and fuel gauge. The capacity of the tank is 10 gallons. The carburetor is a

Zenith 1″ vertical, with choke and needle adjustment rod on dash. The hot spot ram's horn type induction manifold is clearly shown. The fuel system, with its gravity

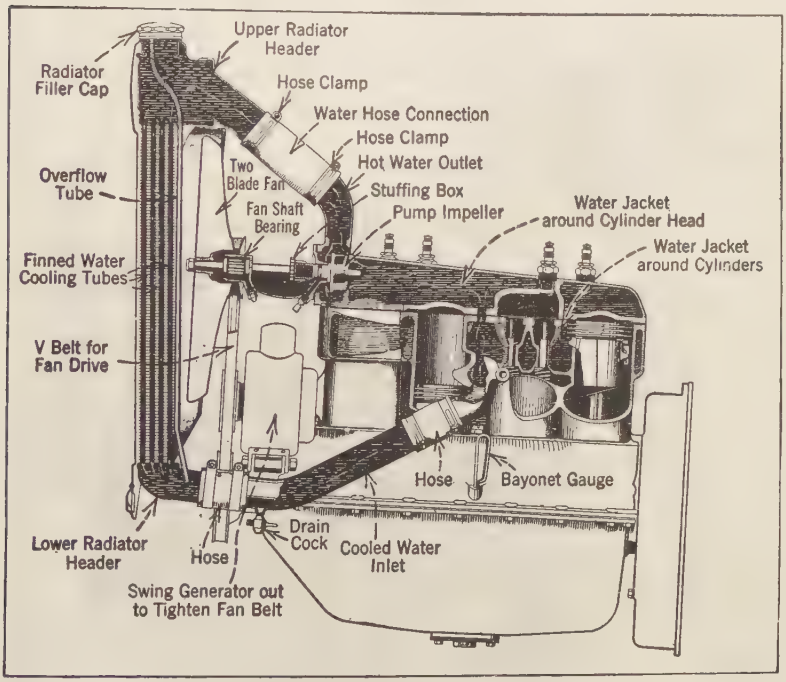

Fig. 7.—Sectional Side Elevation of Ford Model A Cooling Method Which Is a Combined Pump and Thermo-Syphon System.

feed and efficient carburetor, is comparable to that of the highest-grade cars.

The electrical system is illustrated in Fig. 9 and is of the usual standard design. The ignition system is of conventional modern design, the time-honored four coils and timer of the old Model T being done away with. One

ignition coil is used, and this is inclosed in a waterproof case. The distributor is located on the top of the engine, thus making it readily accessible and protecting it from

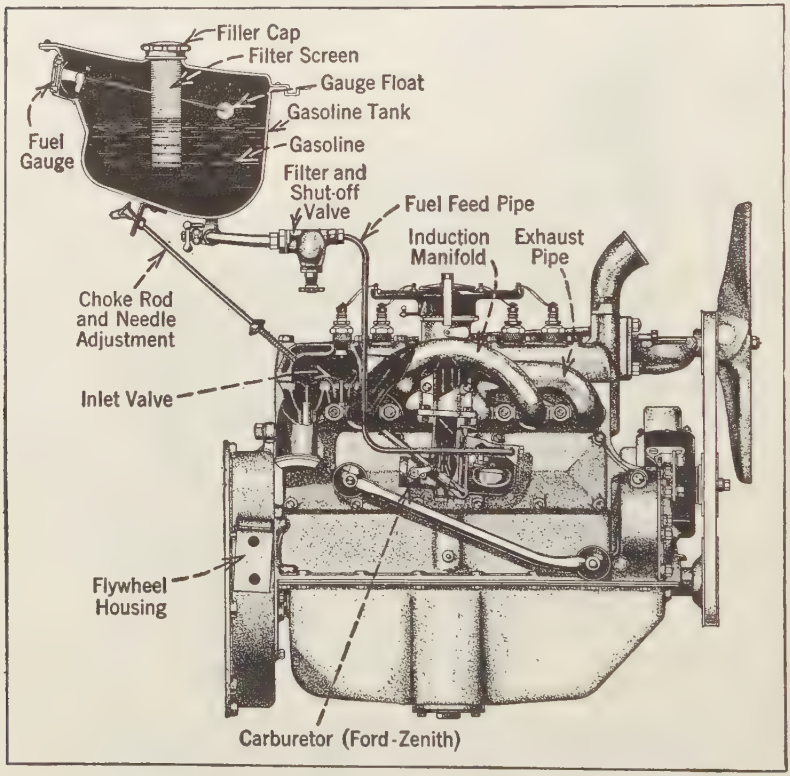

Fig. 8.—The Ford Model A Fuel System and Carburetor Installation.

oil and moisture. Connections from the distributor to the plugs are made by short bronze springs. A coincidental lock is placed in the ignition circuit. This not only replaces the regular ignition switch, but in the "off" position it grounds the entire circuit. A steel conduit

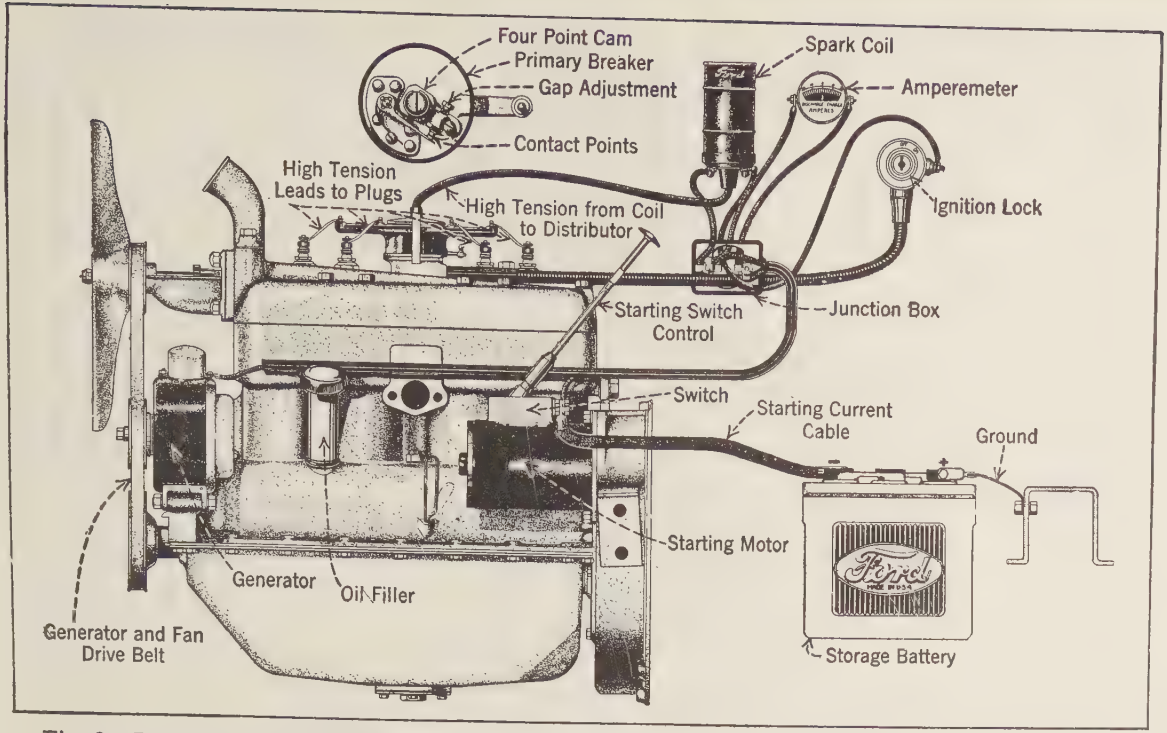

Fig. 9.—Ignition and Starting System of the Ford Model A Car. Note Construction and Location of Distinctive Ignition Distributor.

leading from the switch to the distributor protects the primary wire. This wire is grounded to the distributor casing, thereby making it impossible for anyone to wire around the device.

As has been mentioned, the generator, which is of Ford design, is driven by the fan belt. The starter is conventional and is mounted on the front of the flywheel housing on the side opposite to the generator. The ignition system is of American Bosch manufacture, but has the Ford name stamped on its units. The new distributor is mounted on top of the cylinder head, where it is driven by a vertical shaft, gear-driven from the center of the camshaft, the lower end of the vertical shaft driving the oil pump.

The cover for the new distributor is of molded composition, and is unique in that it has extensions running about 4 in. fore and aft over the cylinder block. Incased in these extensions are the leads for the various spark plugs. These leads are brought to the top of the extensions, where short brass strips are fastened down with round finger nuts. The other ends of these strips attach directly to the plugs. The coil for the new ignition system is mounted on the front of the dash.

Transmission System and Brakes.—The car has a three-speed-and-reverse selective sliding gear transmission with standard gear shift. The main shaft runs on ball bearings, while the gear cluster on the stationary secondary shaft is mounted on roller bearings, only the reverse idler having a plain bearing. This construction will at once be recognized as unusual in the lower-priced class. All gears are made of heat-treated chromium steel. In conjunction with this transmission, use is made of a

multiple disk dry clutch, with four driving and five driven disks. This design is comparable with transmissions found in cars selling at ten times the price of the Ford Model A, and is shown in Fig. 10. The steering gear is

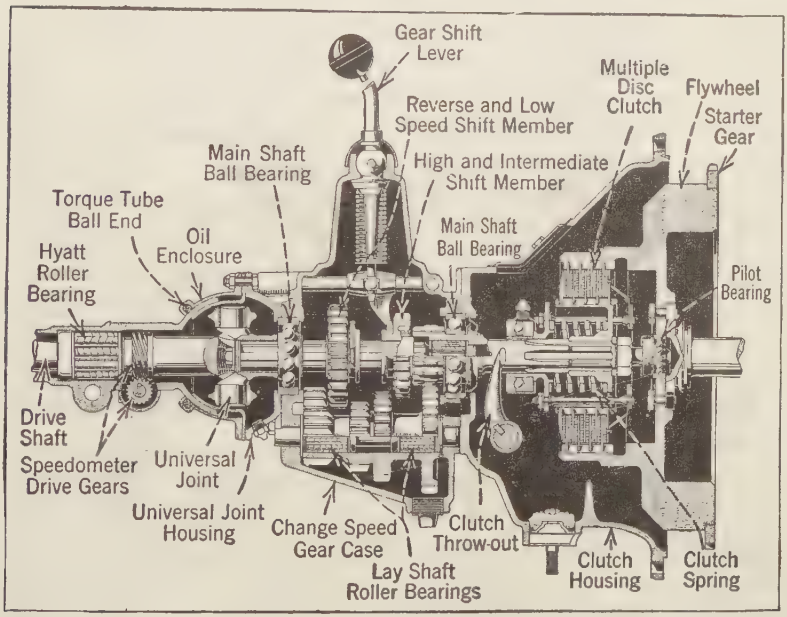

Fig. 10.—Sectional View of Ford Model A Multiple Disc Clutch and Three Speed Sliding Gear Transmission. Note Liberal Use of Anti-friction Bearings.

of the irreversible wheel and sector type and is shown at Fig. 11. The housing of the steering gear is of forged steel and has the tubular steering column welded to it. The ratio of the steering gear is 11¼ to 1. The steering wheel is of large diameter and is made entirely of steel, covered with hard rubber. The lighting switch and horn button are conveniently located on top of the wheel.

As formerly, torque tube drive is used. This torque

tube is tapered from about the middle of its length forward to the universal joint housing, and is bolted to the axle housing at the rear. Radius rods are of hollow elliptic section and connect by a ball joint to the torque

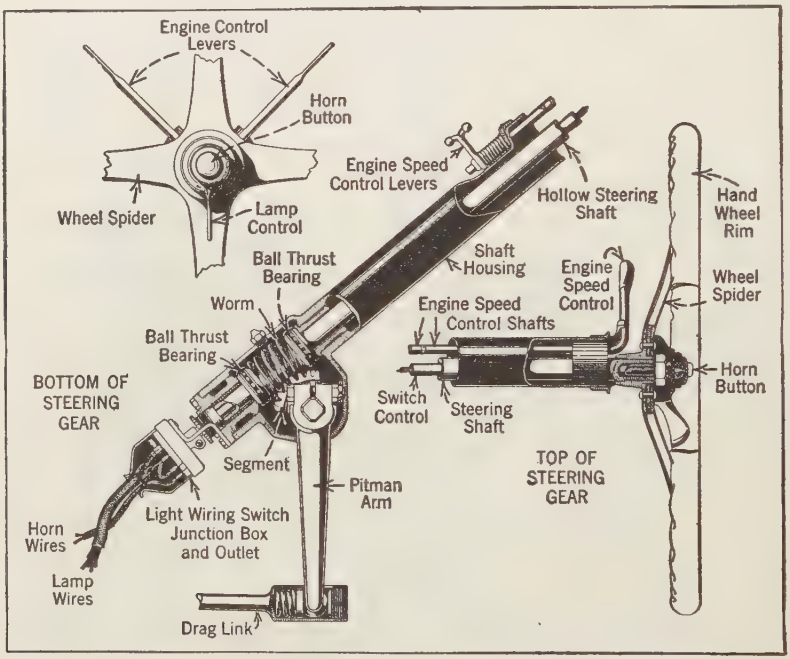

Fig. 11.—The Ford Model A Steering Gear is a Non-Reversible Worm and Segment Type.

tube immediately back of the transmission. A built-up rear axle housing is used, with the two sides of the housing bolted to the central cylindrical part inclosing the differential and drive gears. Two large, hollow-head plugs are used for filling with oil and draining respectively. Axle shafts are keyed to the wheel hubs. There

is no support for the axle shaft inside of the axle housing, but the load is taken by the axle housing itself from the wheel hubs directly, the latter being mounted on pilot roller bearings on case-hardened steel sleeves pressed onto the ends of the housing. The construction of the driving gear and differential assembly can be easily determined by examination of the illustrations in Fig. 12, while the rear wheel hub and bearing construction are easily determined by consulting the sectional view at Fig. 13.

A three-quarter floating rear axle is employed, and the axle shafts carry none of the weight of the car. The axle housings are made entirely of steel and are built up by welding steel forgings to steel tubing. The differential housing, to which these axle housings are bolted, is made of rolled channel steel. The wheels are carried on roller bearings on the axle housing, hence the shafts are not called upon to carry the weight of the car. All bearings in the rear axle are of the roller type, and the drive is by spiral bevel gears. The wheels, which are commonly referred to as wire wheels, are really steel spoked wheels. Each wheel is assembled by welding and becomes one piece of metal. This prevents the spokes from coming loose, and each spoke has a tensile strength of 4,000 lbs. As the outside spokes do not cross, and as there are only 30 spokes in each wheel, the wheels are particularly easy to clean.

Of interesting design are the mechanical four-wheel brakes. These are of the internal, two-shoe type and are self-centering. Smooth action and ease of adjustment are assured. All adjustments are made from outside, without removing any parts and without special tools. Both the brake pedal and the lever operate all four

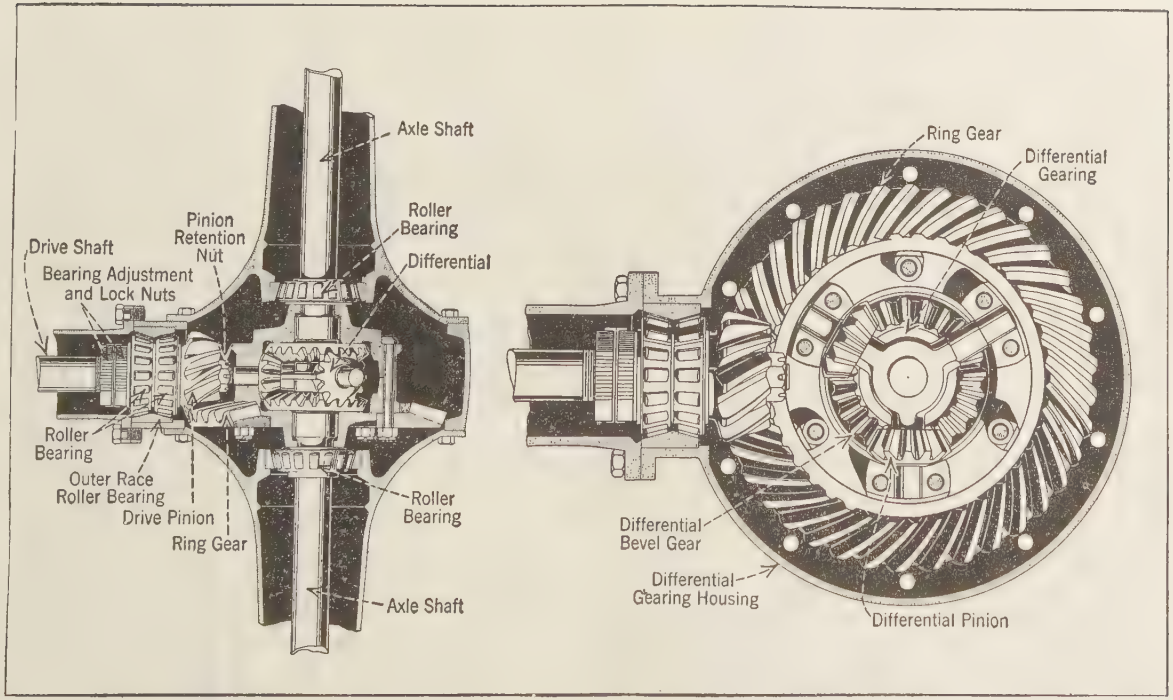

Fig. 12.—Sectional Views Outlining Construction of Bevel Driving and Differential Gearing of Ford Model A Rear Axle. Note Use of High Grade Taper Roller Bearings and Spiral Bevel Gears, Features Found in Higher Priced Cars. Plan Sectional View of Differential Housing Shown at Left, Side Sectional View at Right.

brakes. The total braking surface is 168 sq. in. In order to assure continued service and easy adjustment, all

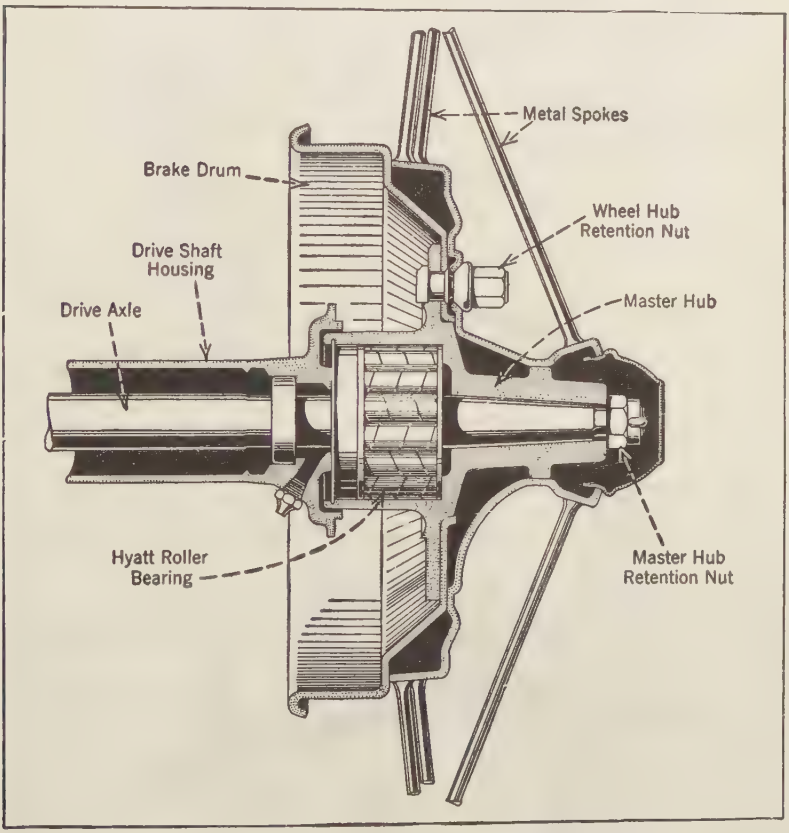

Fig. 13.—Sectional View of Ford Model A Rear Wheel Showing Large Hyatt Roller Bearing for Hub Support.

brake working parts are cadmium-plated, thus making them rust-proof. The brake actuating rods are clearly indicated in diagrams at Fig. 14, which shows the front

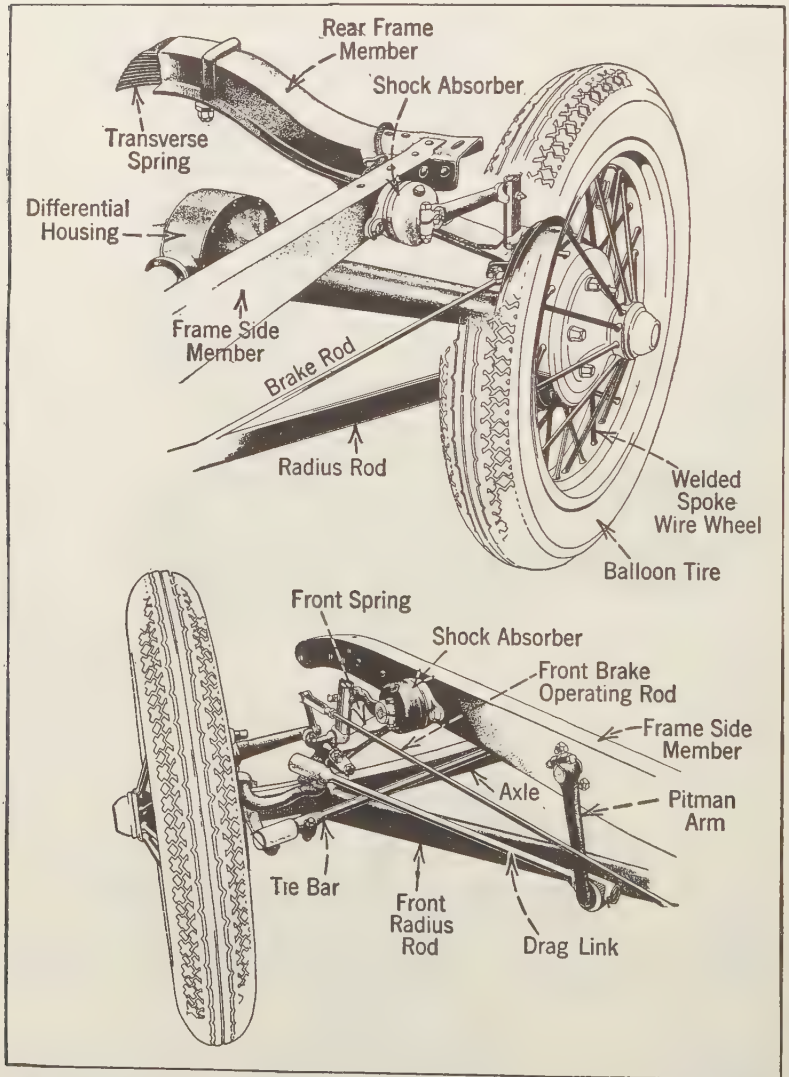

Fig. 14.—View of Rear Corner of Ford Model A Frame at Top Shows Transverse Rear Spring and Shock Absorber Installation. Front Corner of Ford Chassis Showing Steering Members and Front Wheel Brake Operating Rod. Note Hydraulic Shock Absorber.

and rear spring construction and the installation of the shock absorbers.

As formerly, the springs are of the transverse semi-elliptic type. They are built of fine spring steel and the leaves are unusually wide and very thin. Each spring is built up of varying sizes and numbers of leaves to give proper flexibility for the particular body style for which the chassis is designed. The action of the hydraulic shock absorbers is adjustable and controls both up and down motion, thus resulting not only in greater comfort to passengers, but also making the car safer. Torque tube drive, which takes up all strain of starting and stopping the car, leaves the rear springs free to perform their sole function—that of carrying the car and passengers. The lubrication of the chassis is by means of a grease gun and special fittings.

Two-shoe construction is used for the internal four-wheel brakes. These "Grey Rock" shoes carry the regulation riveted woven brake-lining. The brakes are rod-operated. The brakeshoes are spread apart by a wedge between rollers on the shoes, as shown in Fig. 15, the wedge push rod passing through the knuckle pin. At the top the shoes are connected by short levers to a bracket which has an adjustment outside of the brake, this adjustment spreading the tops of the shoes apart to take up wear. The brake operating pressure is equalized between front and rear. From the pedal a short rod runs back to a cross-shaft under the center cross-member, the pull being transmitted by means of bell cranks to two horizontal shafts below them. The outer ends of the latter shafts are not rigidly supported, but can move back and forth. Attached to these outer ends are double-

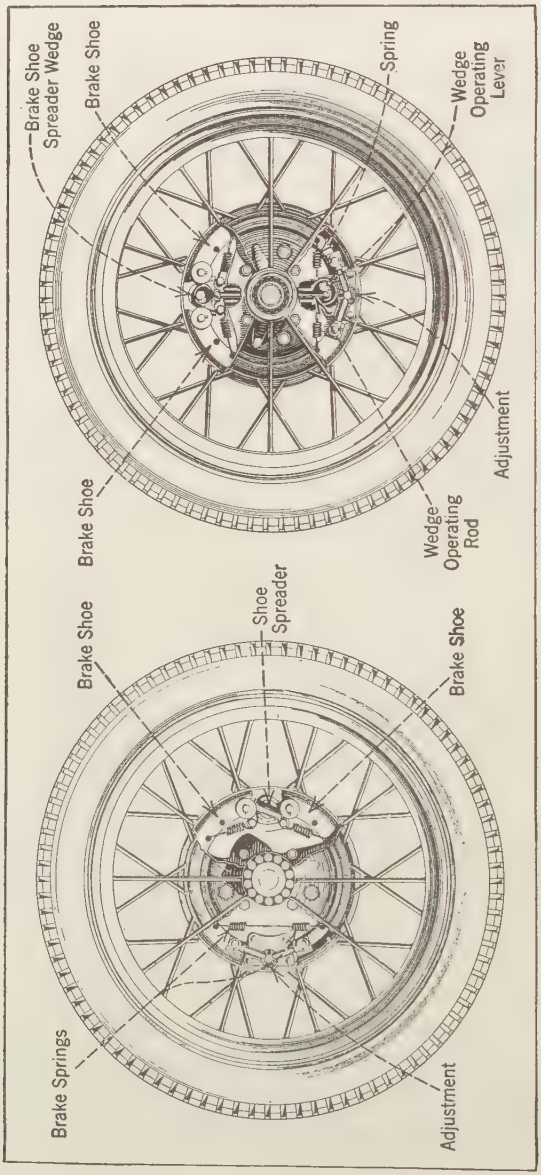

Fig. 15.—View of Rear Wheel of Ford Model A Car at Left Shows Expanding Two-Shoe Brake. The Illustration at the Right Shows the Method of Actuating Front Wheel Brake by a Rod Passing Through Steering Spindle Bolt.

armed levers, the upper arm actuating the rear wheel brake.

The car has a wheelbase of 103½ in. and a tread of 56 in. The rear axle reduction is 3.7 to 1. The minimum road clearance is 9½ in. The center section of the front axle is made of chromium steel. Brake diameters are 11 in. all around and the length of the lining is 14 in. per wheel, the width of the lining being 1½ in., and the thickness 3/16 in. The total braking area is 168 sq. in. The front spring is 1¾ in. wide; the rear, 2¼. All springs are made of chromium steel. The pressed steel frame is of 5/32 in. stock, and the section is 4 in. deep.

The Ford Model A Truck.—Truck models in the new Ford line are rated at 1½ tons with single rear wheels, and 2½ tons with dual rear wheels. Four-wheel brakes, worm-drive rear axles, torque tube drive, cantilever rear springs, and welded steel-spoke wheels are used on both models, which are practically identical except for rear wheel equipment. The powerplant is the same as that embodied in the new passenger cars consisting of a four-cylinder 3⅞ by 4¼ in. engine with battery-distributor ignition and oil and water pumps, multiple-disk clutch and three-speed sliding gear transmission. An additional two-speed auxiliary transmission is offered at extra cost. Front axle, front wheel brakes and steering gear are substantially the same as the passenger car units.

An inclosed cab and express, stake and platform bodies are available. Cabs are all steel and are finished in imitation leather, and doors, which are equipped with crank window regulators, are similar to those used on the passenger cars. The gearshift lever is in the center and the hand brake lever on the left. The light control switch is placed above the steering wheel and the spark

and throttle levers are below it, but quadrants are not provided. A carburetor control rod is beneath and forward of the cowl on the right, and the gasoline shut-off valve may be reached from the driving compartment. The express body is all steel except the floor and sills, which are of seasoned wood. This body is 7 ft. 2 in. long and 4 ft. wide, while the stake body measures 8 ft. 1½ in. inside length and 5 ft. 8 in. width, the racks extending 26 in. above the floor.

Distance from the back of the cab to the rear of the frame is approximately 81¼ in., and from back of cab to center of rear axle about 52 in. The height of the frame is approximately 31 in. at the rear and 27½ in. at the rear of the cab. The frame tapers outward from the rear, being about 33½ in. wide at the cab and 40½ in. at the rear end. The rear axle is of the three-quarter floating type, with rear wheel loads taken by roller bearings on the outside of the housing. The assembly embodies two axle housing halves bolted together and an overmounted worm with double external adjustments. Standard gear ratio is 5 to 1. Two radius rods are employed on the torque tube and the axle end of each rod is used to support the inner end of the brake shaft. Two rear wheel brake drums, which are 14 in. in diameter, inclose internal brakes of the rigid-shoe type. Two shoes are used in each brake, and they are divided on a horizontal line with the operating cam at the front and the adjustable anchorage at the rear.

The frame has an overall length of 171⅝ in., and the depth is 6 in. with flange width of 2¾ in. The bottom of the side rail tapers upward from the trunnion mountings for the rear springs to the rear end. Five heavy channel cross-members are used, the rear member being

offset downward and fitted with a bracket for carrying the spare wheel, or wheels, below the body. The next member forward is of U-section with wide flanges, and is arched to provide clearance for the axle housing. Third carries the forward end of the torque tube and the next carries the front propeller shaft, or the bearing between the two transmissions if the dual unit is used. The front cross-member mounts the engine front support, the radiator and the transverse front spring. In addition, the rear engine supports virtually form an additional cross-member.

Wheel base is 131½ in., compared with 124 in. on the former truck. The rear axle is similar to the unit formerly used, and the necessary extension of the power line is accomplished by use of an inclosed intermediate propeller shaft. At the rear of the transmission a tube with a ball end similar to that on the front of the torque tube is mounted within the ball cap, and this tube and the propeller shaft extend to a frame cross-member where the universal joint, ball and cap assembly are duplicated. The auxiliary transmission, when supplied, is placed back of the regular unit and in place of the front part of the intermediate propeller shaft.

The 17-leaf rear springs are located outside the frame rails and are shackled to the frame at the front end and pass below the trunnion mounting on the side of the frame. Connection with the rear axle housing is made by a split member which encircles the housing. The main leaf of the spring is practically level and has little if any camber.

Auxiliary Two-Speed Transmission.—The dual transmission is of the planetary constant-mesh type and provides a reduction of 1.47 to 1. It has three planet pinions

which turn around a sun gear and mesh with the large internal gear; being similar in this respect to the Model T steering gear. This auxiliary transmission is controlled by means of a separate internal-and-external gear clutch provided for this purpose ahead of the planetary gear-

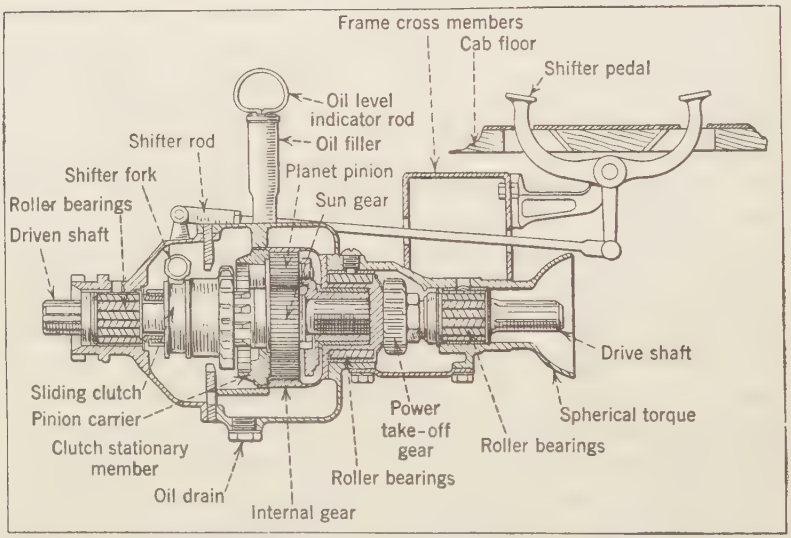

Fig. 16.—Longitudinal Section of the Auxiliary Two Speed Transmission for Ford Model A Truck Showing Planetary Gears and Positive Clutches.

ing. In direct drive, of course, there is no relative motion of the working gears, since the sliding member of the clutch mentioned locks the planetary system, which latter is mounted on roller bearings as shown by the accompanying illustration, Fig. 16.

For low speed, the clutch member locks the sun gear of the planetary system so it cannot revolve. The drive is then taken from the engine through the large internal

gear of the planetary system, forcing the three planet pinions to revolve around the sun gear. Since the sun gear is stationary, the planets do not rotate around the axis of the transmission as rapidly as the internal gear, thereby providing a reduction which in this transmission is about 32 per cent. The cage which supports the three

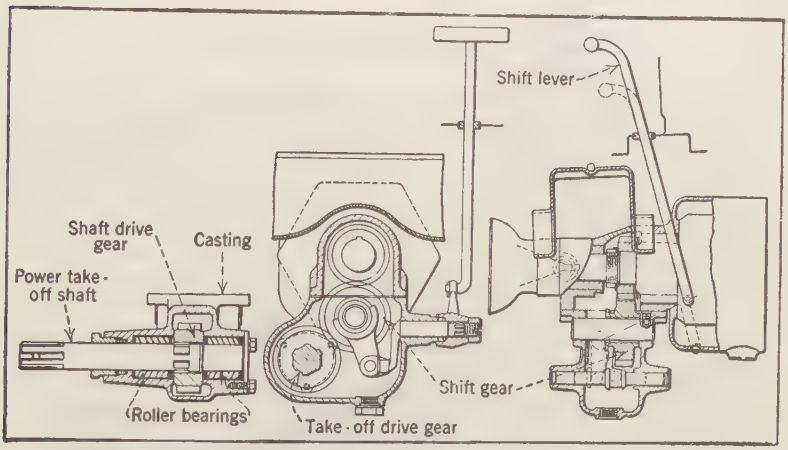

Fig. 17.—Suggestion for Power Take-Off Arrangement to Use in Connection with Ford Auxiliary Transmission.

pinions is connected to the driven shaft, which transmits the torque to the rear axle.

The auxiliary transmission is foot-controlled. There are two pedals projecting through the cab floor. By depressing one pedal, the auxiliary transmission is locked and therefore disengaged, while by depressing the other pedal, it is engaged. It is claimed that the pulling capacity of the truck is increased 47 per cent by the use of this transmission. In direct drive, speed and pull are the same as with the standard truck without the auxiliary transmission.

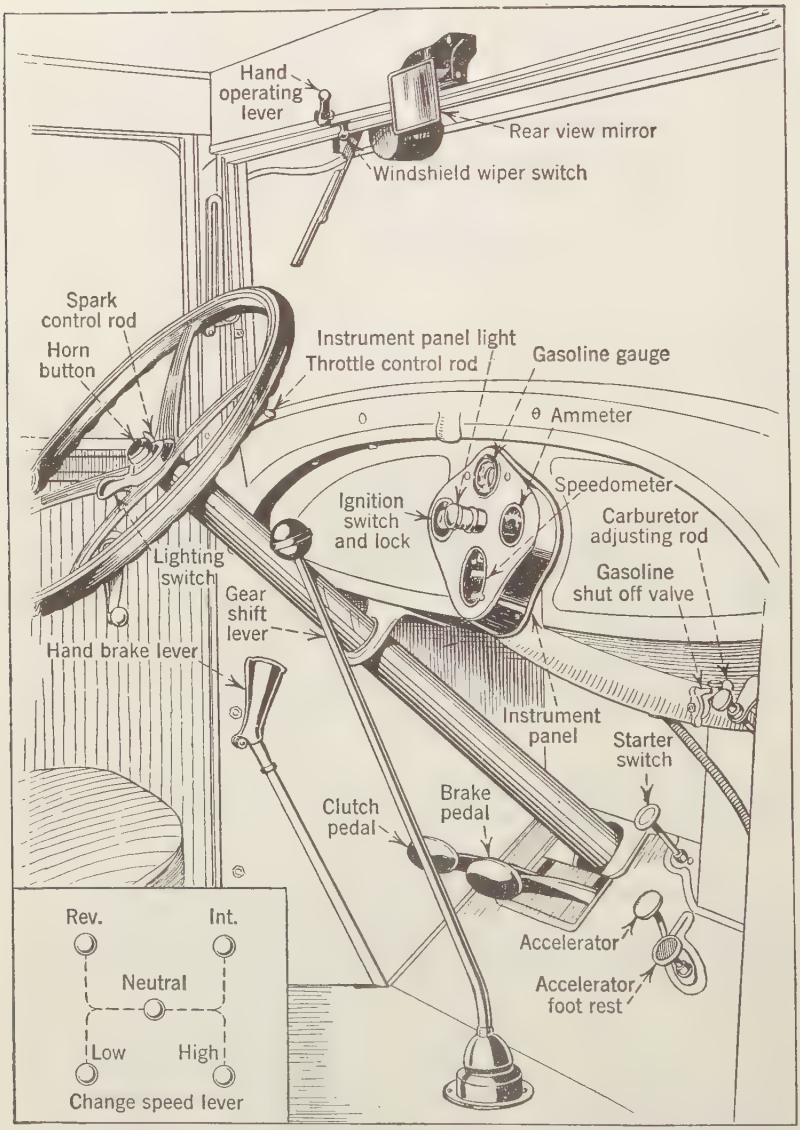

Fig. 18.—Instruments and Control Levers of Ford Model A Cars Follow Conventional Practice. Inset Shows Standard Gear Shift Lever Positions.

This transmission is provided for the new Ford truck as optional equipment at extra cost. It is also provided with a power take-off gear for use with dump bodies, etc. The power take-off itself is not supplied by the Ford Motor Co., which furnishes the suggested design reproduced herewith at Fig. 17.

OPERATING FORD MODEL A CAR

Filling the Radiator.—Before starting the car, see that the radiator is filled with clean fresh water. The cooling system holds approximately three gallons. If in winter, use anti-freeze solution (procurable from any Ford dealer). As the proper cooling of the engine is dependent upon the water supply, it is important particularly with a new car to see that the radiator is kept well filled. Any steaming causes loss of water as will leaks in hose or radiator.

Filling the Gasoline Tank.—The tank has a capacity of ten gallons. The gasoline gauge on the instrument board panel indicates the amount of gasoline in the tank. Gasoline can be drained from the tank by opening the petcock in the sediment bulb located on the engine side of the dash. The screen in the gasoline tank filler neck should occasionally be removed and cleaned. IMPORTANT—After cleaning be sure to replace this screen. Also see that the small vent hole in the gasoline tank cap does not become clogged. If the vent hole is clogged the gasoline will become air bound and fuel supply will be irregular.

Proper Oil Level. — Before starting the engine, make sure there is a sufficient supply of medium light, high grade engine oil in the oil pan. If there is not enough oil, more should be added through the breather pipe lo-

cated at the left side of the engine (a metal cap covers it). Five quarts of oil is the amount required in the oil pan. To determine the correct oil level, use the indicator, which is of the bayonet type, located on the left side of the engine just to the rear of the breather pipe as follows: Pull out the indicator—wipe it off—re-insert the indicator and again remove it. The mark made by the oil indicates its level. When the oil reaches the point marked "F" on the indicator, it is at the proper level. Under no circumstances should the oil be permitted to get below the point marked "L" as any attempt to run the engine with too little oil may seriously damage the parts. The letter "F" indicates "full," the letter "L" means "low." When replacing the oil level indicator, see that both the short and long ends of the indicator enter the opening in the crankcase. Failure to insert both ends into the opening permits the oil to leak out as the opening is not fully closed.

Before Starting the Engine. — Be sure the gear shift lever is in neutral position—i.e., the position in which it can be moved freely from side to side, as in any standard gear shift car.

Advance the throttle lever, located under the steering wheel (right hand side), about three notches, or until the accelerator pedal moves slightly downward. The Ford Model A control levers and instruments are shown at Fig. 18.

Pulling down the throttle lever or pressing on the accelerator pedal, controls the quantity of gas entering the cylinders, and regulates the speed of the engine. In the Model T there was no accelerator pedal. Carburetor control was entirely by hand lever.

Place the spark lever (left hand) at the top of the

quadrant (the notched quarter-circle on which the lever is operated). This is the retard position. The spark lever regulates the timing of the spark which explodes the gas in the cylinders. Readers who are familiar with the Model T will note the changed location of engine controls.

Always retard the spark lever when starting your car. Starting the engine with the spark advanced may cause the engine to kick back, and damage the starter parts. After the engine is started, advance the spark lever all the way down the quadrant.

Theft-Proof Lock.—The Ford type electro-lock used in the ignition switch is a combination switch and theft-proof lock affording full protection for the car and meeting the exacting requirements of the underwriters as regards theft insurance. To unlock the electro-lock, simply insert the switch key into the ignition switch and turn the key to the right. This releases the cylinder of the lock, which snaps forward and closes the ignition circuit. When the cylinder is released the engine can be started in the usual manner, AND THE SWITCH KEY WITHDRAWN FROM THE LOCK.

To shut off the engine, push in on the cylinder of the lock until it snaps back in the lock position. This shuts off the ignition and locks the car in a positive manner.

Starting the Engine.—1. Release the lock cylinder by turning the switch key to the right. 2. See that the spark lever is retarded; the throttle lever advanced three or four notches on the quadrant, and the gear shift lever in neutral position. 3. If the engine is cold, turn the carburetor adjusting rod one full turn to the left, to give it a richer mixture for starting. This rod serves both as a choke for starting and as an enriching adjustment.

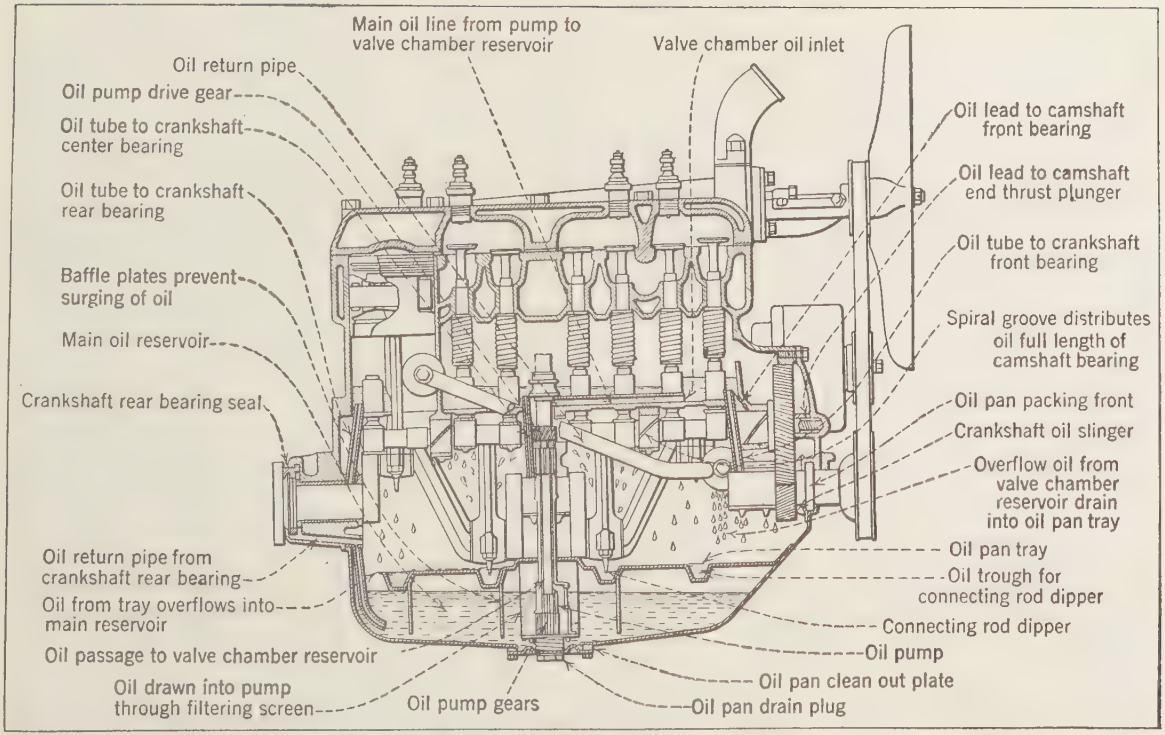
Main oil line from pump to valve chamber reservoir
Valve chamber oil inlet
Oil return pipe
Oil pump drive gear
Oil tube to crankshaft center bearing
Oil tube to crankshaft rear bearing
Baffle plates prevent surging of oil
Main oil reservoir
Crankshaft rear bearing seal
Oil lead to camshaft front bearing
Oil lead to camshaft end thrust plunger
Oil tube to crankshaft front bearing
Spiral groove distributes oil full length of camshaft bearing
Oil pan packing front
Crankshaft oil slinger
Overflow oil from valve chamber reservoir drain into oil pan tray
Oil pan tray
Oil trough for connecting rod dipper
Connecting rod dipper
Oil pump
Oil pan clean out plate
Oil pan drain plug
Oil return pipe from crankshaft rear bearing
Oil from tray overflows into main reservoir
Oil passage to valve chamber reservoir
Oil drawn into pump through filtering screen
Oil pump gears

Fig. 19.—Sectional View of Ford Model A Engine Showing Method of Lubricating Internal Mechanism by Combined Pump and Splash System.

Next pull back the rod, at the same time pressing down on the starter button and release the choke rod; next advance the spark lever. When the engine warms up, turn the choke rod back to its normal position one-quarter turn open.

When starting a warm engine, do not pull back the choke rod unless the engine fails to start on the normal mixture, as there is a possibility of flooding the engine with an over-rich mixture of gas. If you should by accident flood the engine, open the throttle and, with the choke rod in normal position, turn the engine over a few times to exhaust the rich gas. If you continue to turn the engine with the choke rod out the flooding will become greater and engine increasingly difficult to start.

Starting the Car.—Release the hand brake lever. With the engine running, disengage the clutch by pushing down the left foot pedal. Move the gear shift lever to the left and back, which is the low speed position as shown in insert in Fig. 18. Gradually release pressure on the clutch pedal, allowing it to return to its normal position, and at the same time increase the speed of the engine by pressing lightly on the accelerator. Second Speed: When the car has reached a speed of five to eight miles per hour, engage second or intermediate speed as follows: Release pressure on accelerator and again disengage the clutch, moving the gear shift lever through neutral to the right and forward, second speed position. Allow the clutch pedal gradually to return to its normal position, and increase the speed of the car until it is running 12 to 15 miles per hour. High Speed: Disengage the clutch as before; at the same time release the pressure on the accelerator and pull the gear shift lever straight back from second speed. Then engage the clutch and increase

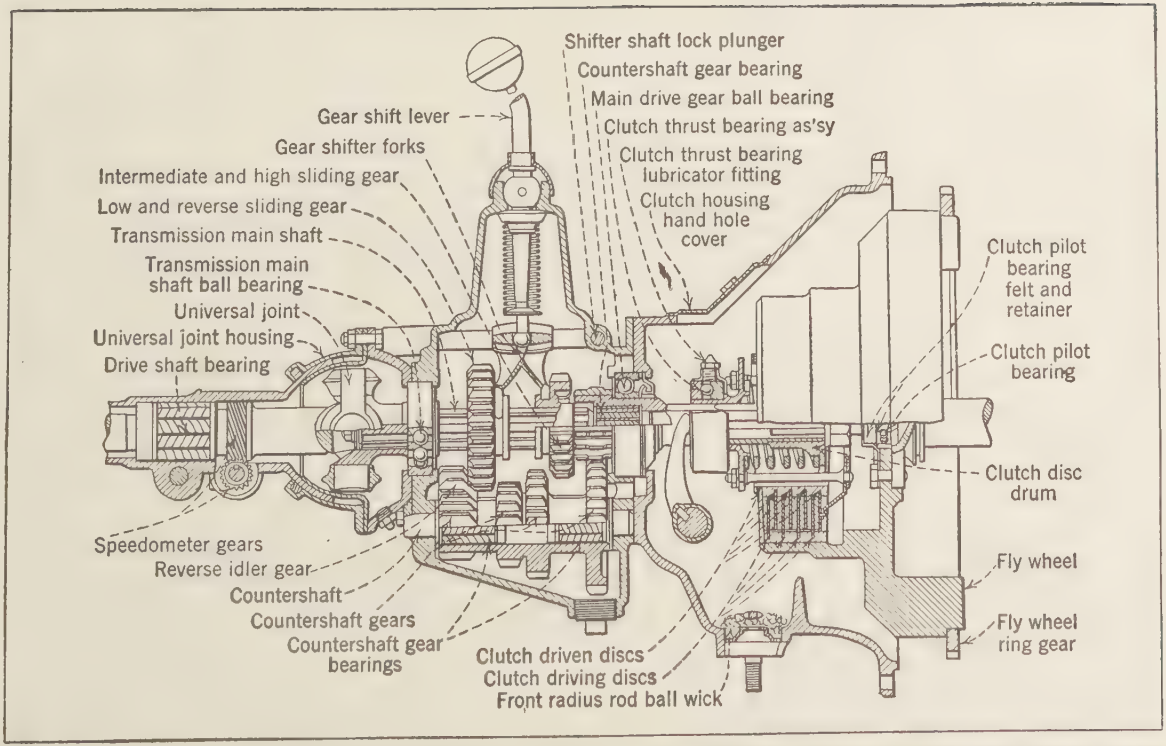

Fig. 20.—Sectional View of Clutch and Gearset Assembly of Ford Model A Showing Clutch and Change Speed Gear Relation.

the speed of the engine, as driving conditions may require.

Shifting Back Into Low Speed.—When shifting from high to second speed, at car speeds not exceeding 15 miles per hour, there should be no hesitation in neutral. The lever should be moved as quickly as possible, from high to second speed. Should it be necessary to shift from high to second speed at higher car speeds, it can be done by the following method: Disengage the clutch and shift into neutral. Reengage the clutch and at the same time accelerate the engine; then disengage the clutch again and shift to second, after which disengage the clutch. With a little experience, this shift can be made quietly.

Descending a Hill. — When descending long, steep grades, have the transmission in gear, the clutch engaged, and the ignition switch on. This allows the engine to turn over against compression and act as a brake. On very steep grades the car should be in second speed gear before descent is started. On exceptionally steep grades the low speed should be used. This increases the braking action of the engine. Always leave the ignition switch on when descending an incline. Shutting off the switch allows raw gas to be drawn into the cylinders, which washes the lubrication off the cylinder walls. Also unexploded gas collects in the muffler, and when the switch is again turned on there is a possibility of blowing out the muffler, which has become filled with highly explosive mixture.

To Stop the Car.—Disengage the clutch by pressing forward on the left pedal and apply the foot brake by pressing forward on the right pedal. Except when a quick stop is necessary, it is advisable to apply the brake

gradually. When driving on wet or slippery pavement the speed of the car should be reduced by applying the foot brake before releasing the clutch. This method of braking prolongs the life of the brake lining, and is a safety factor.

In bringing the car to a final stop, keep the clutch disengaged until the gear shift lever has been moved into neutral position. To stop the engine, push in on the electro-lock cylinder until it snaps back into the lock position. The driver should endeavor to so familiarize himself with the operation of the car that to disengage the clutch and apply the brakes becomes automatic—the natural thing to do in case of emergency.

To Reverse the Car.—The car must be brought to a stop before attempting to reverse its direction. To shift into reverse, proceed as in shifting into low speed, except that the gear shift lever is moved to the left and forward.

The Spark Control.—For normal driving, drive with the spark lever fully advanced. When the engine is under a heavy load, as in climbing steep hills, driving through heavy sand, etc., the spark lever should be retarded sufficiently to prevent a spark knock. This is a pronounced knock, which is sometimes mistaken for a worn bearing.

Driving the Car.—The different speeds as required to meet road conditions are obtained by varying the pressure on the accelerator, which in turn controls the motor. Practically all the running speeds needed for ordinary travel are obtained in high gear; the low and second speed gears are used principally to give the car momentum in starting, and when the engine is subjected to a heavy load.

Caring For the New Car.—A new machine requires

more careful attention during the first few days it is being driven than after the parts have been thoroughly "worked in." To obtain the best results, a new car should not be driven faster than 30 to 35 miles per hour for the first 500 miles. The oil in the engine should be changed after this distance has been covered, as there may be a few metallic particles or sand in a new engine. Never start out with your car until you are sure it has plenty of oil, water and gasoline.

See that an air pressure of 35 pounds is maintained in all tires. Under inflation causes more tire expense than anything else.

Inspect your battery every two weeks and keep it filled to the proper level with distilled water. If the water is allowed to evaporate below the top of the plates the life of the battery will be seriously affected.

Let the Ford dealer or expert Ford repairman go over your car once a month, making any mechanical adjustments necessary to keep your car in proper running order.

Do Not Rest Foot on Clutch Pedal. — Do not make a practice of resting your foot on the clutch pedal while driving, as this may cause the clutch to slip and unnecessarily wear the facing on the discs. This is called "riding the clutch" and causes premature clutch trouble in any make of car. The correct clearance or play for the clutch pedal is approximately ¾ in. That is when the clutch pedal is depressed there should be about ¾ in. play in the pedal before it starts to disengage the clutch. As the clutch facings wear this clearance or play gradually grows less. Consequently it should occasionally be checked. Under no circumstances should the car be driven without clearance or play in the clutch pedal.

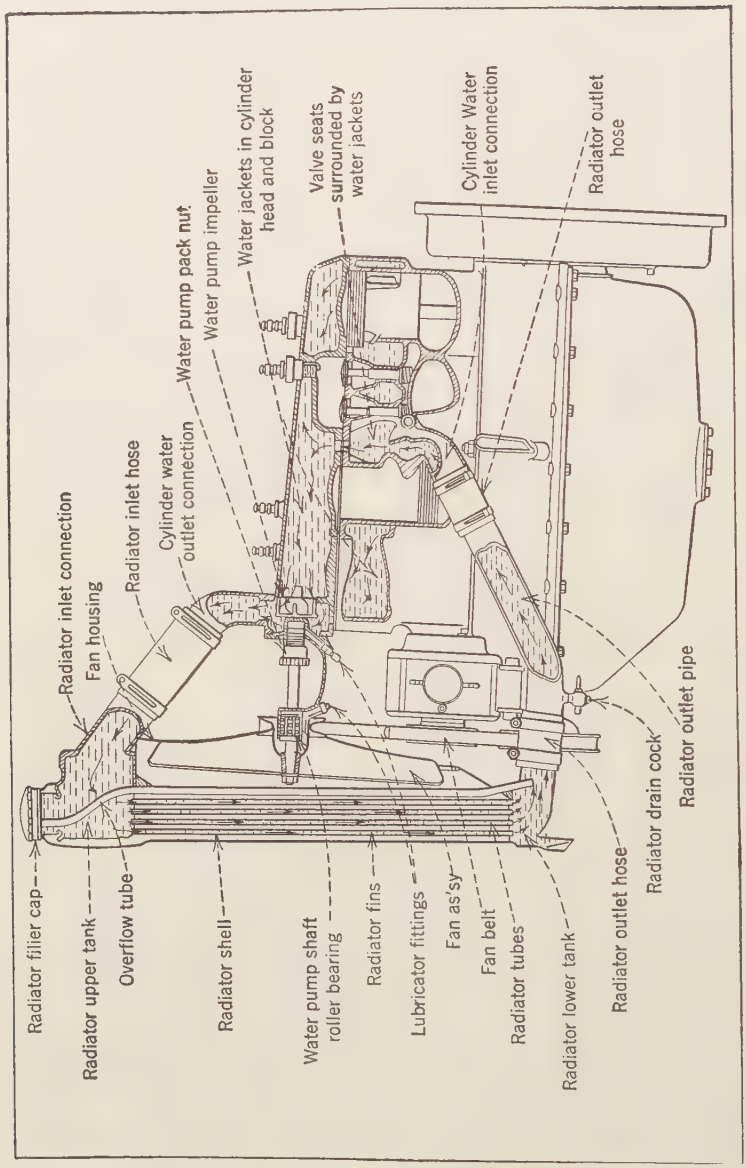

Fig. 21.—The Ford Model A Engine Water-Cooling System Illustrated in Detail.

The adjustment is easily made by removing a steel clevis pin and turning the release arm rod after it is lifted

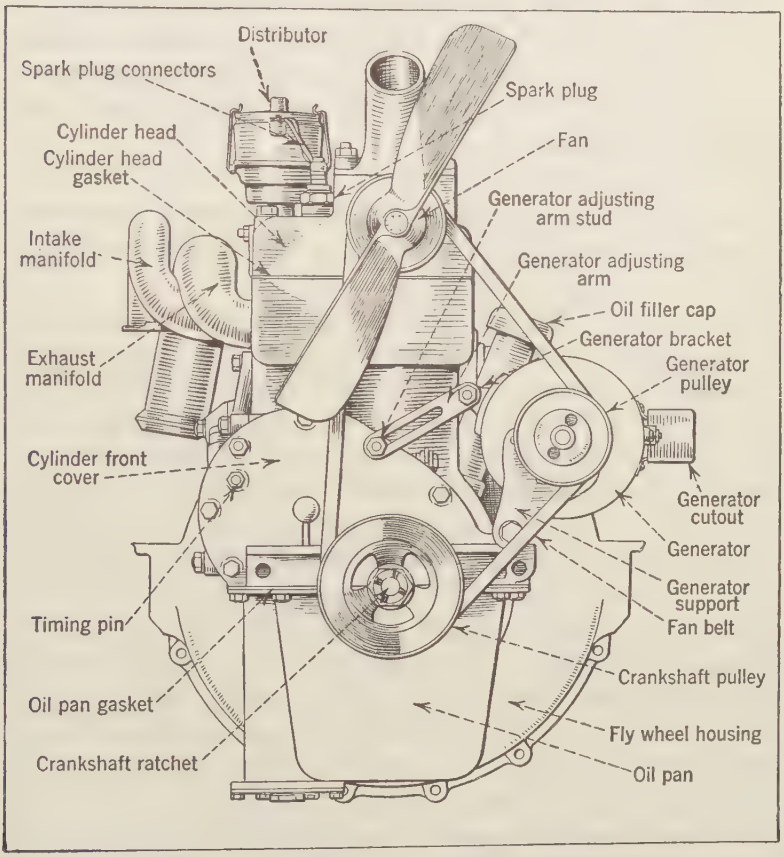

Fig. 22.—Front View of Ford Model A Engine Showing Cooling Fan and Generator Drive by V Belt, Also Method of Adjusting Belt Tension.

from the actuating lever. Screwing the rod in augments the clutch pedal play. Screwing the rod out reduces the play. After making adjustment, be sure to replace steel pin and cotter key.

The Ford Lubricating System.—The purpose of lubricating is to reduce friction between moving surfaces. The oiling chart gives full information for lubricating the Ford car and can be obtained from any agent. Proper lubricating has a vital effect on the life of your car; consequently, you should follow the instructions of the manufacturer very carefully.

All parts of the engine are lubricated from the oil reservoir in the oil pan by the Ford Pump, Splash and Gravity Feed. Only medium light, high grade engine oil should be used in the engine.

Oil of the proper kind reaches the bearing surfaces with greater ease and cuts down friction and reduces heating. It should, of course, have sufficient body so that the pressure between the two bearing surfaces will not force out the oil and allow the metal to come in actual contact. Too light in body is as undesirable as too heavy body in oil. Heavy and inferior oils have a tendency to carbonize quickly, also "gum up" the piston rings, valve stems and bearings. In cold weather a light grade of oil having a low cold test is absolutely essential for the proper lubrication of the car. Such oils can be secured from any Ford service station or reliable supply house.

Oil conforming to the following specifications is recommended for use in the Model "A" engine. The engine lubricating system is shown at Figure 19.

Draining the Oil Pan.—It is advisable to clean out the oil pan by draining off the dirty oil when the new car has been driven 500 miles, and thereafter to repeat this operation every 500 miles. The oil should be warm before draining. It is a good plan, especially in cold weather, to remove and clean the oil pan clean-out plate once a month.

WINTER OIL

COLOR	FLASH	FIRE	VISCOSITY		COLD SET	GRAVITY
Not darker than	(Open Cup) °F.	°F.	Saybolt-Universal 100 °F.	210 °F.	°F.	Beaume
No. 5	390 Min.	450 Min.	450 Sec. Max.	58 Sec. Max.	20 Max.	22 Min.

SUMMER OIL

COLOR	FLASH	FIRE	VISCOSITY		COLOR SET
Not darker than	(Open Cup) °F.	°F.	Saybolt-Universal 100 °F.	210 °F.	°F.
No. 6	400 Min.	450 Min.	650 Max.	66 Max.	45 Max.

Lubricating the Differential.—Every 5,000 miles the lubricant in the differential should be drained and the housing flushed with kerosene. New lubricant should then be added until it reaches the level of the oil hole in the housing

Lubricating the Transmission.—About once every 5,000 miles the gear lubricant should be drained from the transmission by removing the drain plug at bottom of transmission case. The interior of the transmission case should be then thoroughly flushed with kerosene and refilled with fresh gear lubricant. The new lubricant is poured into the transmission through the filler hole, located at the right hand side of the transmission case. Pour sufficient lubricant in until it reaches the level of the filler hole.

Lubrication of the Clutch Bearing. — The clutch pilot bearing at the front end of the clutch is thoroughly packed with grease when the car is assembled, and it will not be necessary to lubricate this bearing until such time as the clutch may be disassembled. When the

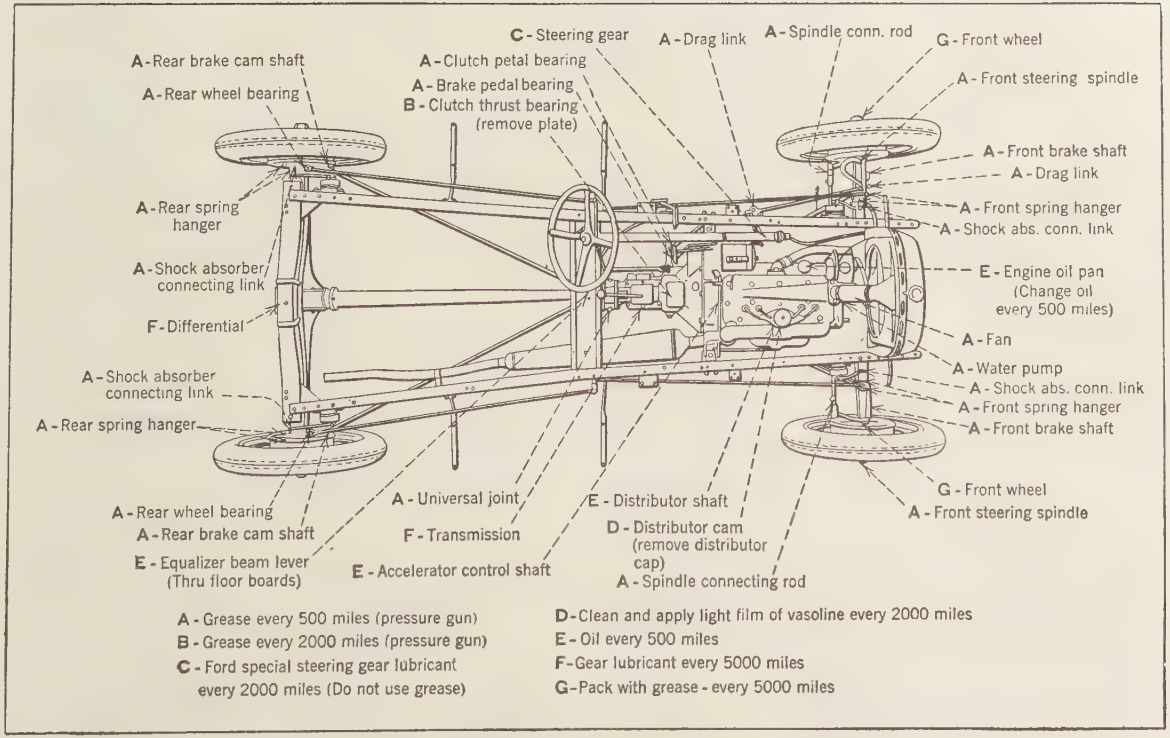
A - Rear brake cam shaft
A - Rear wheel bearing
A - Rear spring hanger
A - Shock absorber connecting link
F - Differential
A - Shock absorber connecting link
A - Rear spring hanger
A - Rear wheel bearing
A - Rear brake cam shaft
E - Equalizer beam lever (Thru floor boards)
C - Steering gear
A - Clutch petal bearing
A - Brake pedal bearing
B - Clutch thrust bearing (remove plate)
A - Universal joint
F - Transmission
E - Accelerator control shaft
A - Drag link
A - Spindle conn. rod
E - Distributor shaft
D - Distributor cam (remove distributor cap)
A - Spindle connecting rod
G - Front wheel
A - Front steering spindle
A - Front brake shaft
A - Drag link
A - Front spring hanger
A - Shock abs. conn. link
E - Engine oil pan (Change oil every 500 miles)
A - Fan
A - Water pump
A - Shock abs. conn. link
A - Front spring hanger
A - Front brake shaft
G - Front wheel
A - Front steering spindle
A - Grease every 500 miles (pressure gun)
B - Grease every 2000 miles (pressure gun)
C - Ford special steering gear lubricant every 2000 miles (Do not use grease)
D - Clean and apply light film of vasoline every 2000 miles
E - Oil every 500 miles
F - Gear lubricant every 5000 miles
G - Pack with grease - every 5000 miles

Fig. 23.—Diagram of Ford Model A Chassis Showing Parts That Need Periodical Lubrication.

clutch is disassembled the bearing should be repacked with a good grade of cup grease.

Approximately every 2,000 miles, lubricate the clutch release bearing. This is done by removing the hand hole cover (see Fig. 20) and turning the bearing until the lubricator fitting is at the top. Lubricate the bearing by means of the compressor grease gun.

IMPORTANT NOTE.—The clutch is a dry disc clutch and under no circumstances should it be oiled.

Greasing the Car.—In order to properly force lubricant to all parts equipped with the conical-shaped fittings, a high pressure lubricating system is employed. With this system the lubricant can be forced in under a pressure of 2,000 pounds or more per square inch, thus assuring a more thorough and positive lubrication than can be accomplished any other way. A compressor is supplied with the tool equipment of each car, and by means of this device lubricant can be forced into all bearings provided with conical-shaped fittings.

Remove top cap and plunger assembly to fill the compressor. Fill the barrel with lubricant. Pack the lubricant solidly. To avoid air pockets, tap the nozzle gently on a board or work bench while filling. To prevent lubrication backing up and soiling hands, FILL UP ONLY TO THE TOP OF THE LETTERING ON THE OUTSIDE OF THE BARREL.

When the compressor is pressed against the conical-shaped fittings, the plunger moves forward, forcing the lubricant in the nozzle directly through the fitting into the bearing, under an extremely high pressure. When the pressure on the handle is released, grasp the barrel of the compressor with one hand and draw back the handle with the other, so as to load the compressor and

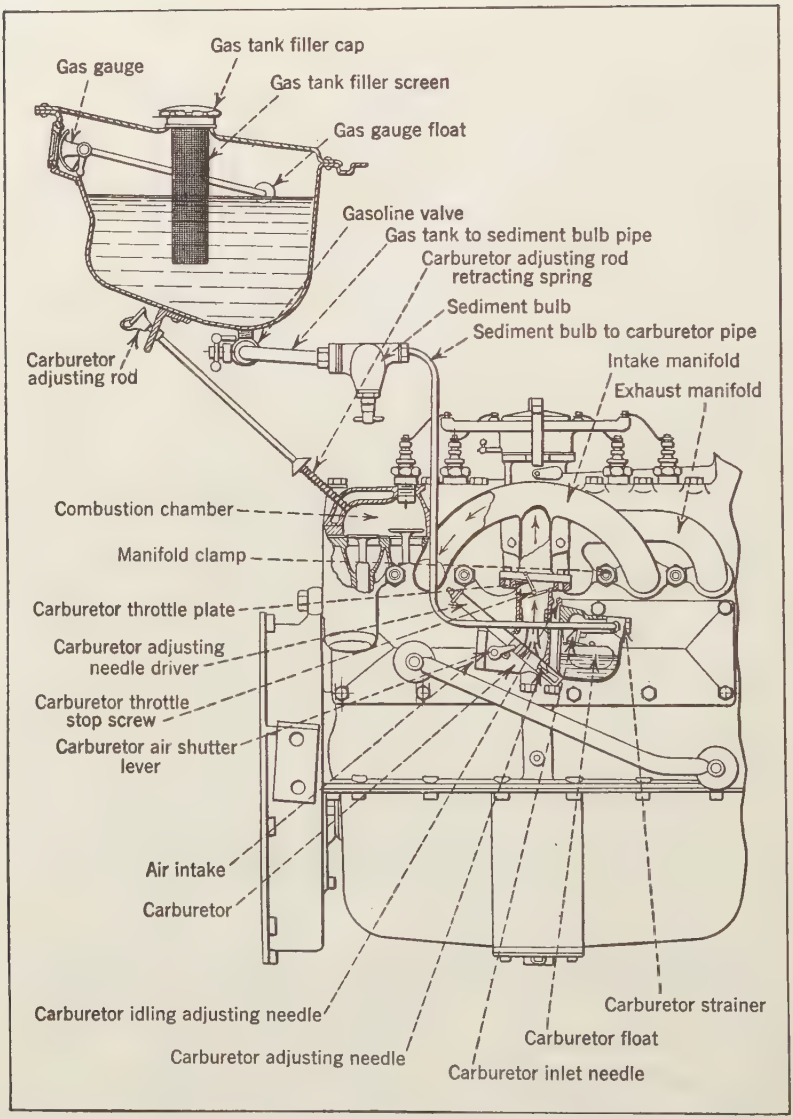

Fig. 24—The Ford Model A Engine in Part Section Showing Units That are Part of the Fuel Supply and Carburetor System.

make it ready to deliver a charge of lubricant with the next forward thrust.

The bearings in the generator and starting motor are lubricated when they are installed in the car, and require no further attention. The distributor should be kept clean and well oiled. Put oil in the oil cup at the side of the distributor every 500 miles. Add sufficient oil to reach the level of the oil cup. Every 2,000 miles remove the distributor cap, clean the lobes of the cam and apply a light film of vaseline.

Cooling the Engine.—The Ford engine is cooled by a circulation of water through the cylinder water jackets which surround the combustion chamber and valve seats. The water is circulated by thermo-syphon action, the flow of water being accelerated by means of a centrifugal water pump located in the front of the cylinder head. This pump draws the heated water from the engine into the upper radiator tank, where it is cooled by filtering through the radiator tubes to the lower tank. The radiator is cooled by means of the fan located just back of the radiator, where it draws a current of air around the radiator tubes. To prevent overheating, keep the radiator well filled. The capacity of the radiator is three gallons and the cooling system parts are clearly shown in illustration at Fig. 21.

Adjusting the Fan Belt.—The fan and water pump both operate from the same shaft. The shaft is driven by a "V" shaped rubber belt, as shown in front view of engine at Fig. 22. The belt is adjusted to the proper tension when the car leaves the factory, and this adjustment should not be changed unless the belt slips. The adjustment is easily made by loosening the generator adjusting arm stud nut, and moving the generator out-

ward. Do not tighten the belt more than is actually necessary to keep it from slipping, as too much pressure from excessive tension will cause undue loading on the pump shaft.

Packing is used in forming a water-tight connection around the water pump shaft. Should the packing become loose, tighten the packing nut. A screw driver is used for this purpose, using it as a pry and resting the blade on the supporting casting. Do not tighten the nut more than is necessary to stop the leak. The point of the screw driver is inserted in one of the slots of the stuffing box nut and rocked about the fulcrum point by bearing on the lever.

The entire circulating system should be thoroughly flushed out several times each season. To do this, open the petcock at the bottom of the radiator outlet connection pipe and insert a hose into the filler neck, allowing the water to flow through the system for about fifteen minutes, or until the water comes out clear.

Care of the Radiator in Winter.—In freezing weather it is necessary to use an anti-freeze solution in the circulating system to prevent freezing of the water and bursting the tubes in the radiator. This cooling solution should be put in with the first approach of cold weather.

Do not overlook the fact that constant evaporation will eventually weaken most anti-freeze solutions, consequently they should be tested frequently, especially in severe weather. It is better to have too rich a mixture of solution than to have too little compound. A suitable anti-freeze solution can be obtained from any authorized Ford dealer. Also complete directions as to the percentage of solution to be used to withstand the varying degrees of cold. As anti-freeze solutions usually contain

alcohol, care should be used when filling the radiator not to spill any of the solution, as it may damage the pyroxylin lacquer finish used on Ford cars. After filling the radiator, be sure the radiator cap is screwed down tight.

Fuel System.—The gasoline is carried in a ten-gallon tank welded integral with the cowl of the car. From this tank the gasoline flows by gravity to the carburetor. There it is mixed with air and drawn into the cylinders through the induction manifold and intake valves by piston suction. A sediment bulb located on the engine side of the dash is provided for draining off water or sediment that may have accumulated in the tank. Occasionally draining the bulb prevents foreign material being drawn into the carburetor.

The Carburetor.—The quantity of gasoline entering into the carburetor is governed by the needle valve. The volume of gas mixture entering the intake manifold is controlled by opening and closing the throttle, according to the engine speed desired by the driver. Since, with the exception of the needle valve and idle adjustment, all of the carburetor adjustments are fixed, about the only thing that could affect the carburetor would be dirt or water getting into it. An occasional cleaning will insure uninterrupted service. To clean the carburetor, remove the filter screen and thoroughly clean the screen by washing it in gasoline. The screen is easily removed by backing out the filter plug at the front of the float bowl. After cleaning, be sure to replace the screen. It is also a good plan to remove the brass plug at the bottom of the carburetor and drain the carburetor for a few seconds, to make sure any water left from condensation will escape.

For economical driving, careful mixture regulation

is important. Reduce the quantity of gasoline in the mixture by turning the adjusting rod to the right as far as possible without reducing the speed of the engine. This is particularly true when taking long drives, where conditions permit a fair rate of speed being maintained, and accounts for the excellent gasoline mileage obtained by good drivers. Turning the carburetor adjustment too far to the right results in a "lean" mixture—too far to the left results in a "rich" mixture. A lean mixture has too much air and not enough gasoline. A rich mixture has too much gasoline and not enough air. A rich mixture causes excessive carbon and overheating; likewise, it wastes fuel. The mixture should be kept as lean as possible without sacrificing the power of the engine. Too rich mixture causes black smoke and foul exhaust; too thin mixture causes popping back in carburetor.

The method of regulating the carburetor for ordinary driving conditions is to turn the carburetor adjusting rod to the right until the needle just seats, then turn the rod back one-fourth (¼) of a turn. Use care in adjusting the carburetor, as turning the needle down too tightly will result in its becoming grooved and the seat enlarged. When these parts are damaged, it is difficult to maintain proper adjustment of the carburetor until a new needle is used.

Fully retard the spark lever when setting idling adjustment. Set stop screw on throttle lever so that engine will run sufficiently fast to keep from stalling when it is idling. Turn the idling adjusting screw in or out until the engine hits evenly without "rolling" or "skipping" (the correct setting of the adjusting screw is approximately two turns off its seat). Next back off the stop screw until the desired engine speed is obtained. This

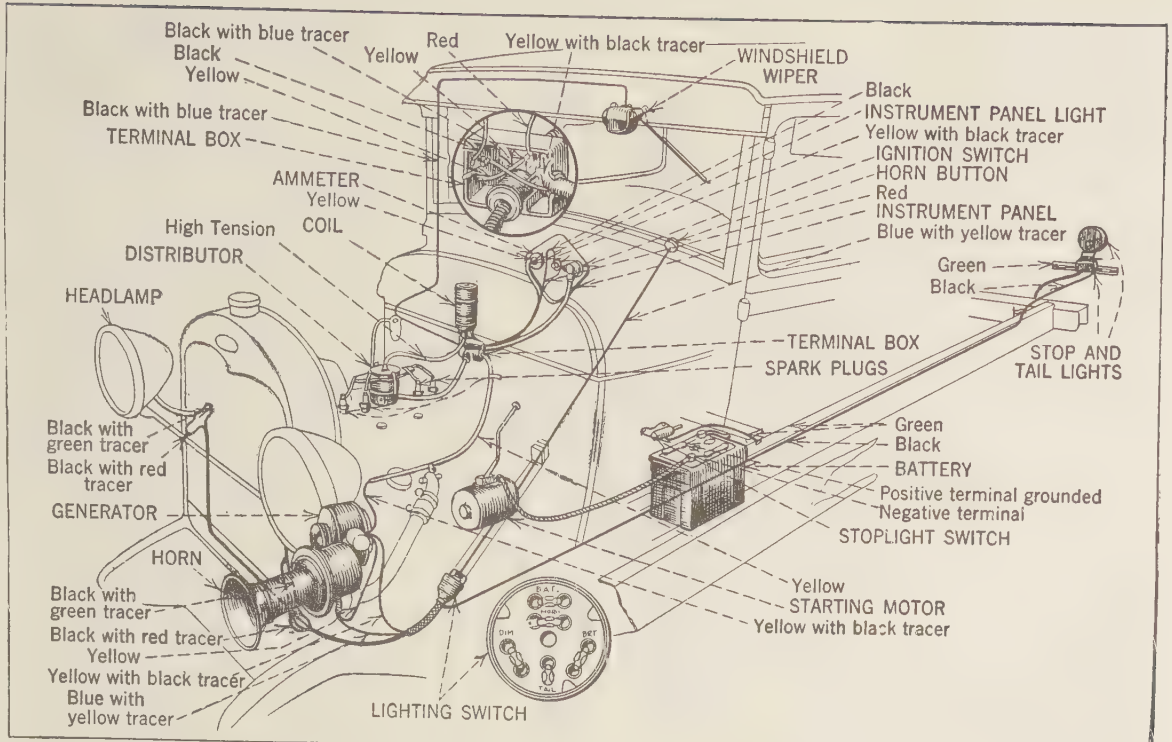

Fig. 25.—Diagram Showing All Electrical System Parts of the Ford Model A Car and Their Location Relative to Each Other.

adjustment should be made with the engine warm. Do not expect a new engine that is stiff to "rock" on compression when stopped, or to idle perfectly at low speed.

Electrical System.—The electrical system of the Ford Model A includes the following equipment, as shown at Fig. 25: Storage Battery, Generator, Starting Motor, Distributor, Ignition Coil, Spark Plugs, Ammeter, Horn, Lamps, Windshield Wiper (on closed cars).

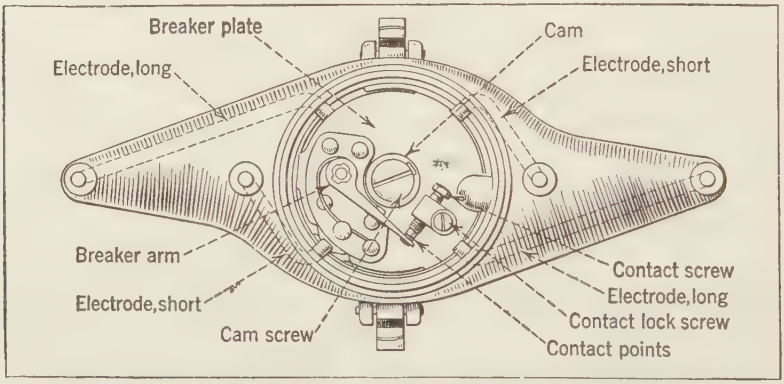

Fig. 26.—Top View of Ignition Current Distributor Showing Make and Break Points.

The current for igniting the gas mixture in the cylinders is provided by the storage battery. The ignition coil transforms the low tension current to a high tension current of sufficient voltage to jump between the points of the spark plugs. The distributor breaker points interrupt the flow of low tension current at regular intervals, while the distributor rotor distributes the high tension current to each spark plug in proper firing order. A complete wiring diagram is presented at Fig. 28.

Adjusting Breaker Contact Points.—The gap between

the breaker points is set at .015 to .018 in. The gap should occasionally be checked to see that the points are properly adjusted. The points are shown at Fig. 26.

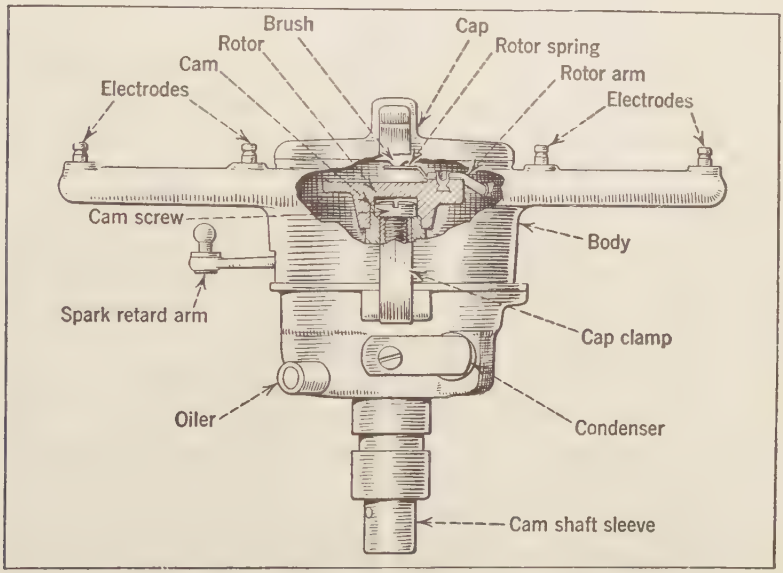

Fig. 27.—Side View of Ford Model A Ignition Distributor.

If the points are burnt or pitted, they should be dressed down with an oil stone. DO NOT USE A FILE.

To adjust the points, proceed as follows:

Lift distributor cap, rotor, and body.

Turn engine over slowly with starting crank until breaker arm rests on one of the four high points of the cam with the breaker points fully opened.

Loosen lock screw and turn the contact screw until the gap is at .015 to .018 in. A standard thickness gauge is used to obtain this measurement.

Ignition Timing.—As the spark must occur at the end of the compression stroke, the timing must be checked from that point. To find the compression stroke and time the spark, proceed as follows:

1. Fully retard spark lever.
2. Check gap between breaker contact points and, if necessary, adjust them as previously described.
3. Screw out timing pin located in timing gear cover and insert opposite end of pin into opening.
4. With the starting crank turn the engine over slowly, at the same time pressing in firmly on the timing pin. When the piston reaches the end of the compression stroke the timing pin will slip into a recess in the camshaft gear.
5. With the pin in place, remove the distributor cover and lift off rotor and distributor body.
6. Loosen cam-locking screw, shown at Fig. 27, until cam can be turned.
7. Replace rotor and turn it until the rotor arm is opposite No. 1 contact point in distributor head.
8. Withdraw rotor from cam and slightly turn the cam in a counter clockwise direction until the breaker points just start to open, then securely tighten cam-locking screw.
9. Replace rotor and distributor cover.
10. WITHDRAW TIMING PIN FROM RECESS IN TIME GEAR and screw it back tightly into the timing gear cover.

The Ford Starting System uses a six-volt, 80 ampere hour, 13-plate battery, designed and built in the Ford factory to meet the requirements of the Ford car.

Every two weeks check the electrolyte in the battery, to see that it is at the proper level. The solution (Electrolyte) should be maintained at a level with the bottom of the filling tube. If below this point, add distilled water until the electrolyte reaches the proper level. Water for battery use should be kept in clean, covered vessels of glass, china, rubber or lead. In cold weather add water only immediately before running the engine, so that the charging will mix the water and electrolyte and prevent freezing. Access to the battery is easily made by removing a small plate located in the floor board in front of the driver's seat. To remove the battery from the car it will be necessary to take out the floor boards. WHEN REPLACING THE BATTERY IN THE CAR BE SURE TO INSTALL IT WITH THE POSITIVE TERMINAL GROUNDED TO THE FRAME, AS SHOWN IN FIG. 25.

Keep the battery filling plugs and connections tight, and the top of the battery clean. Wiping the battery with a rag moistened with ammonia will counteract the effect of any of the solution which may be on the outside of the battery. A coating of vaseline will protect the terminals from corrosion. It is of vital importance that the battery is firmly secured in its supporting brackets at all times. If clamps are loose, the battery will shift about in the compartment and result in loose connections, broken cells, and other trouble. When repairs are necessary, or if the car is to be laid up for the winter, take the battery to a Ford dealer for proper attention and storage. Do not entrust your battery to inexperienced or unskilled hands.

The Generator.—The generator is of the Power House type, so called because of its similarity to the type of

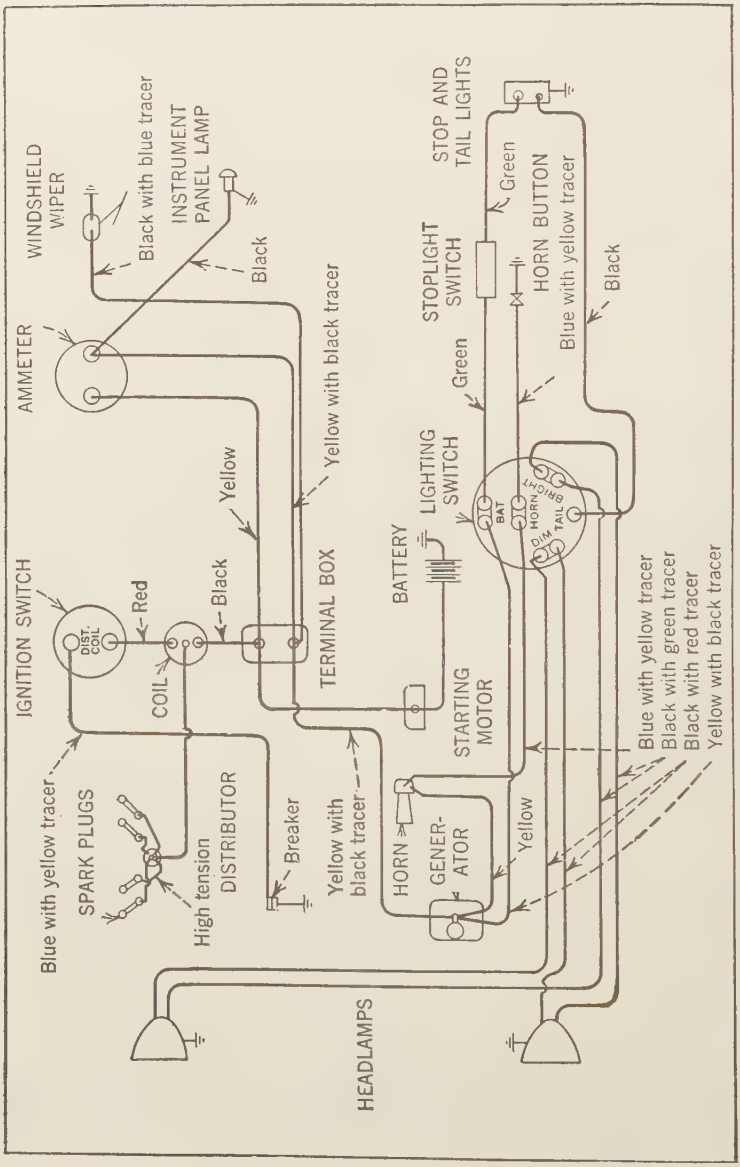

Fig. 28.—**Wiring Diagram of the Ford Model A Showing All Units and Connections.**

generator used in power houses. It is mounted on the left hand side of the engine. During winter months the charging rate should be adjusted to 14 amperes; in the summer this rate should be cut down to 10 amperes. The rate can, of course, be increased or decreased to meet individual requirements. For example, the owner who takes long daylight trips should cut down the charging rate to 8 amperes, to prevent the battery overcharging. On the other hand, the owner who makes numerous stops, should increase the normal rate if his battery runs down.

To increase or decrease the generator charging rate, remove generator cover and loosen field brush holder lock screw. The field brush holder can be easily identified, as it is the only one of the five brush holders that operates in a slot in the brush holder ring and which is provided with a locking screw. The remainder of the brush holders are riveted to the ring and are not movable. To increase the charging rate, shift the field brush holder in the direction of rotation; to reduce the rate shift the brush in the opposite direction. The output of the generator is indicated by the ammeter located on the instrument panel.

The starting motor is mounted on the left side of the engine. It requires no attention beyond seeing that the cable connection is clean and tight.

Ignition Coil.—The ignition coil mounted on the dash receives the low tension current from the battery, and transforms it into the high tension current necessary to produce the spark at spark plugs. Occasionally inspect the wire connections at the coil, distributor and spark plugs, to see that they are clean and tight. Loose connections cause misfiring.

The Spark Plugs.—The spark plugs are the medium through which the electric current ignites the gasoline charge in the cylinder. Hard starting or misfiring of the engine may be caused by dirty spark plugs or incorrect spark plug gaps. Keep the plugs clean and the gap set to .025 in. There is nothing to be gained by experimenting with different makes of spark plugs. The spark plugs with which Ford engines are equipped when they leave the factory are best adapted to the requirements of the Ford engine and have been determined to be so by exacting factory tests.

The Ammeter.—The ammeter is located on the instrument panel. It registers "charge" when the generator is charging the battery, and "discharge" when the lights are burning and the engine only running about 10 miles per hour. If the engine is running above 15 miles per hour and the ammeter does not register "charge," consult a Ford dealer or competent electrician specializing on automotive work.

Operation of the Lights.—The lighting system consists of a dash light, two head lamps and a combination tail and stop light, operated by a switch located at the top of the steering wheel. The headlamp bulbs are of the 6-8 volt, double filament gas-filled type. The major filament is 21 candle power. The small bulb used in the tail light, the instrument panel light, is of the 6-8 volt, single contact, three-candle power type. The stop lamp bulb is a single contact, 21 c.p. bulb. All of the lamps are connected in parallel so that the burning out or removal of any of them will not affect the others. Current for the lamps is supplied by the battery.

When replacing burned-out bulbs, make certain that you get genuine Ford bulbs, as satisfactory results can-

not be obtained with the many inferior bulbs now on the market. Genuine Ford bulbs have the name FORD marked on the base. They insure your headlights meeting the lighting requirements of the various states.

Headlamp Requirements.—When the car is delivered, the headlamps are properly focused and aligned, and will pass the lighting requirements of all states. Should the lamps get out of focus or alignment, they should immediately be focused and realigned. Ford dealers are equipped to do this work, or if you have the proper facilities you can make the adjustment.

Align and focus headlamps with empty car standing on a level surface in front of a white wall or screen 25 feet from front of headlamps. This wall must be in semi-darkness or sufficiently shielded from direct light so that the light spots from the headlamps can be clearly seen. The wall must be marked off with black lines, as shown in Fig. 29 A and B. Details for making the layout are shown in Fig 29 C.

To Focus.—Turn on bright lights. Focus by means of screw at back of lamps; keep one lamp covered while focusing the other. Adjust the bulb filament at the focal center of the reflector to obtain an elongated elliptical spot of light on the wall, with its long axis horizontal. (See Fig. 29 A.) In focusing, adjust the bulb to obtain as good contrast and as well-defined cut-off across the top of the spot of light as possible. With lamps thus focused for the "bright" filament, the "dim" will be in satisfactory position.

Alignment.—Loosen nut at bottom of bracket and tilt headlamps to desired angle.

The tops of the bright spots on the 25-foot wall are to be set at a line 33 inches above level of surface on

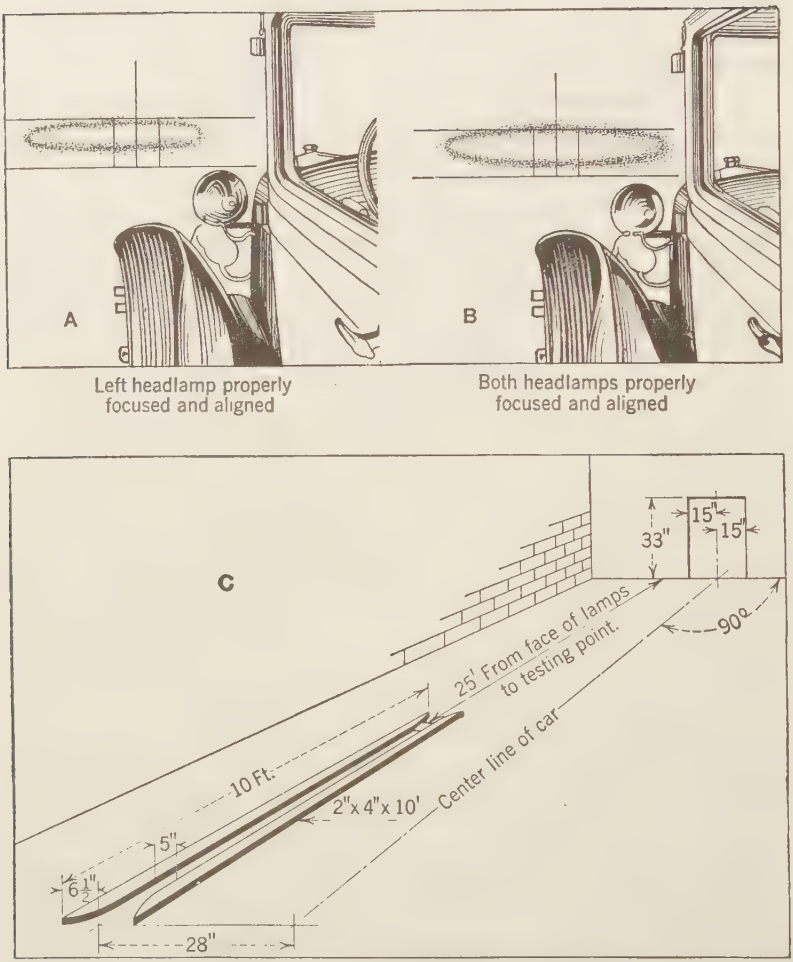

Fig. 29.—Methods of Focusing and Aligning Ford Model A Headlamps Shown at A and B. Shop Layout for Focusing and Adjusting Headlamps Shown at C.

which car stands. With top line thus set for empty car, the headlamps will also have the proper tilt under full loads, as required by the various states.

The beam of light from each headlamp is to extend straight forward; that is, the centers of the elliptical spots of light must be 30 inches apart.

Proper alignment of headlamps is readily checked by means of a horizontal line on the wall in front of the car, 33 inches above the level surface on which the car stands, and two vertical lines 30 inches apart, each one 15 inches from center line of car (see Fig 29 C). Proper alignment of car relative to marks on the wall may be readily provided by use of wheel guide blocks for one side of the car, as shown in Fig 29 C. If it is impossible to tie up the floor space required by these blocks, marks painted on the floor may be used to show where one set of wheels should track and where the car should be stopped. In order to avoid any confusion, the new layout can be painted with red paint and the old that is needed with model T painted with black.

Care of Running Gear.—Every few weeks the front and rear axles should be carefully gone over to see that all nuts and connections are tight, with cotter pins in place. The spring clips should be inspected occasionally to see that they are tight.

The front wheels should be jacked up periodically and tested for smoothness of running and excessive side play. To determine if there is excessive side play, grasp the sides of the tire and shake the wheel. Do not mistake loose spindle bushings for loose bearings. Insert a cold chisel between spindle and axle when making this test to take up any spindle bushing play.

Adjusting Front Wheel Bearing.—If there is excessive play in the bearing, it can be adjusted as follows:

Remove wheel.

Withdraw cotter key and tighten adjusting nut until the hub just starts to bind.

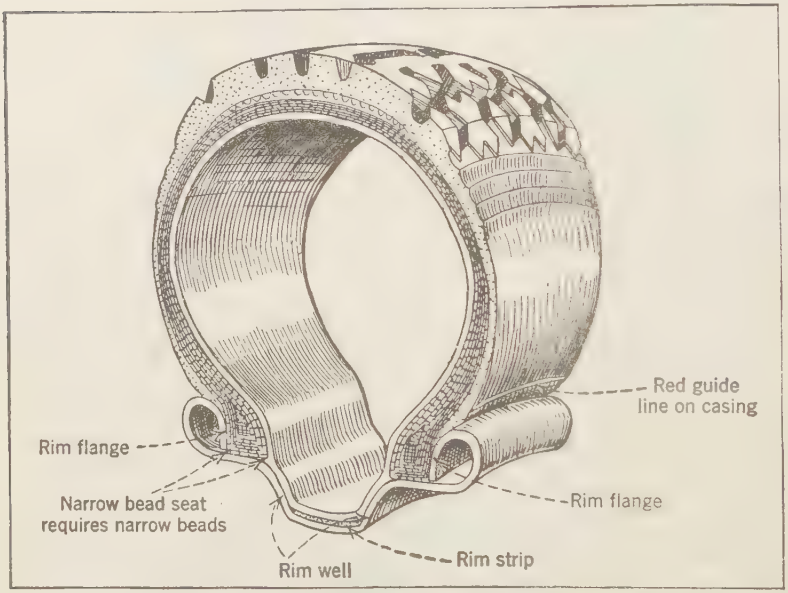

Fig. 30.—Sectional View Showing Drop Center Rim Used with Ford Wire Wheels and Balloon Tire Installed Thereon.

Then back off the adjusting nut one or two notches until the hub can be freely revolved.

Before placing the wheel, BE SURE TO INSERT COTTER KEY IN ADJUSTING NUT.

The springs should be lubricated occasionally with oil or graphite. This will restore the original flexibility of the springs and improve the riding quality of the car.

Ford Wire Wheels.—To remove the Ford wire wheels, jack up the side of the car from which the wheel is to be withdrawn and screw off the five hub bolt nuts. The wheel can then be removed. When replacing a wheel, tighten each hub bolt nut a few turns at a time. Then follow around hub, tightening each nut firmly. If nuts are not drawn up evenly, the wheel will not run true.

Removing Tires From Ford Wire Wheels (Drop Center Rims).—Remove valve cap and lock nut and place wheel so that the valve is at the top. Let all air out of tube. Push valve stem up into tire. Working both ways from the valve stem, press the casing together and down into the rim well, approximately one foot each side of the valve stem. Insert tire iron under both beads at point opposite valve and force tire over rim. The tire can be then removed from the wheel with the hands.

Mounting Tire on Ford Wire Wheels (Drop Center Rims).—Inflate tube until it is barely rounded out, and insert tube in casing. (CAUTION: Never use a tire flap when mounting tires on a Ford wire wheel.) With wheel placed so that valve stem hole is at top, place casing and tube on wheel, with valve in valve stem hole. (See Fig. 31 A.) Working both ways from the valve stem, press the casing together and down into the rim well, until lower part of casing can be forced over rim flange at bottom. A tire iron may be used, if necessary. (See Fig 31 B.) Raise tire up (see Fig. 31 C) until it is perfectly centered on rim and beads are seated on bead seats. Inflate tube to not more than two pounds pressure and work casing back and forth to insure proper setting of tire, indicated by red line on tire being equally spaced from rim all way around. (See Fig 31 D.) CAUTION: With Ford wire wheels (drop center rims) use only casing

with red centering line just above the rim flange, and tubes marked "for drop center rims."

It is particularly important that the red line (Fig.

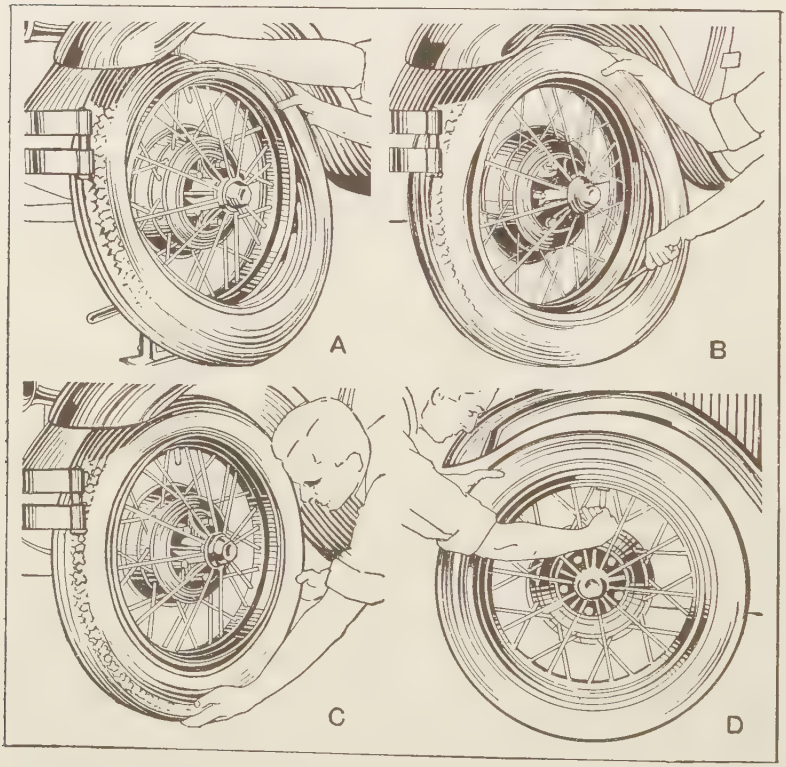

Fig. 31.—Sketches Showing Manipulation of Tire on Ford Drop Center Rim.

30) shows an even distance from the rim all around on both sides before fully inflating tire. Put valve nut on valve, inflate tire to 35 pounds and screw valve cap down tightly. (See Fig. 31 D.) With Ford wire wheels, tires

can be more easily changed with wheel mounted on axle or tire carrier than by laying the wheel down on ground.

Tires should never be run partially inflated, as the side walls are unduly bent and the fabric is subjected to stresses which cause what is known as rim cutting. KEEP BOTH FRONT AND REAR TIRES INFLATED TO 35 POUNDS AND CHECK THE PRESSURE ONCE A WEEK. Never run on a flat tire, even for a short distance. Skidding also shortens the life of the tires. Avoid locking the wheels with the brakes—no tire will stand the strain of being dragged over pavement. Avoid running in street car tracks, or bumping the sides of the tire against the curbing. To get most service at least expense, tires should be inspected frequently and all small cuts or holes properly sealed or repaired, thus preventing dirt and water working in between the rubber tread and the fabric, causing blisters or sand holes. The construction of Ford tire and drop side rim is clearly shown at Fig. 30.

When a car is idle for any appreciable length of time, it should be jacked up to take the load off the tires. If the car is laid up for several months, it is best to remove the tires. Wrap up the outer casings and inner tubes separately, and store them in a dark room, not exposed to extreme temperatures. Remove oil or grease from the tires with gasoline.

Brakes.—The braking system consists of four internal expanding brakes—one brake located within each wheel. The brakes are brought into operation by depressing the foot brake pedal or pulling back the hand brake lever. Each brake consists of two rigid shoes faced with lining; a hardened steel brake drum and special operating and adjusting parts. (See Fig. 32.) When the brakes are

applied the brake-shoes are expanded against the drum, the pressure of the shoes setting up a strong braking resistance which stops the car. An operating cam expand the shoes in the rear wheels, while in the front wheels a wedge is used.

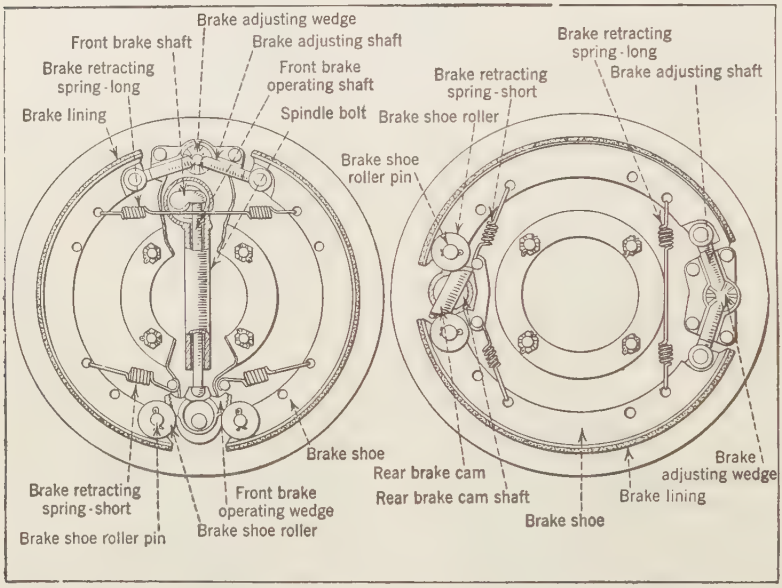

Fig. 32.—Parts of Ford Model A Internal Expanding Wheel Brakes and Shoe Spreading Mechanism.

Ordinary adjustments necessitated by natural wear of the linings are made as follows:

Jack up one wheel at a time and with the hand brake lever fully released turn the adjusting wedge (see Fig. 33) on each wheel until the wheel starts to bind. Then back off the adjusting wedge one notch, or until this wheel revolves freely. Each wheel should be adjusted in this

manner. When all of the adjustment on the adjusting wedges is used up, it will be necessary to reline the brakes. When this becomes necessary we suggest you take your car to an authorized Ford dealer. They are provided with special relining equipment.

UNDER NO CIRCUMSTANCES SHOULD OWN-

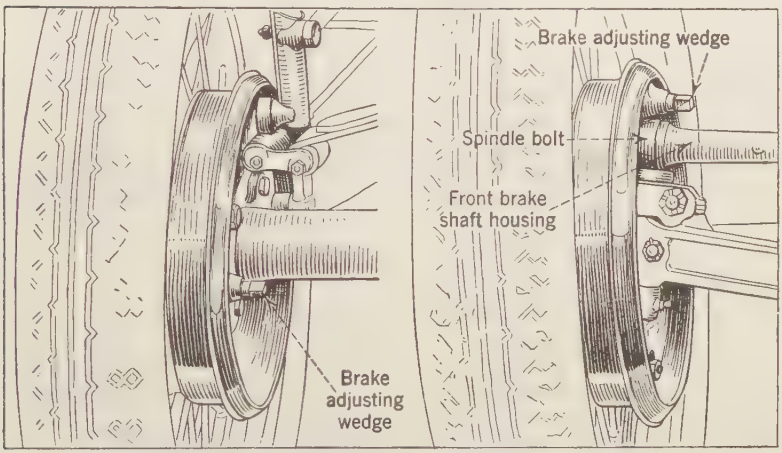

Fig. 33.—Where the Ford Model A Brake Adjusting Wedges Are Located.

ERS ATTEMPT TO MAKE ADJUSTMENTS BY TURNING UP THE CLEVISES ON THE BRAKE RODS, AS THIS WOULD RESULT IN THE BRAKES BEING THROWN OUT OF ADJUSTMENT AND CAUSE UNEQUAL WEAR ON THE LININGS.

Shock Absorbers.—Ford hydraulic double-acting shock absorbers operate entirely on the principle of hydraulic resistance, and are shown installed at Fig. 34. Glycerine is forced from one chamber to another by the movement of the lever arm. The working chamber is automatically kept full by the glycerine in the reservoir. As the shock

absorbers are accurately adjusted at the factory, it should not be necessary to alter this adjustment except in rare cases, where more or less shock absorber action is desired.

The reader will observe a needle valve with an arrow pointer extending through the center of the shaft. Surrounding it numbers from 1 to 8 are stamped. The average setting is with arrow pointing at 2 for the front

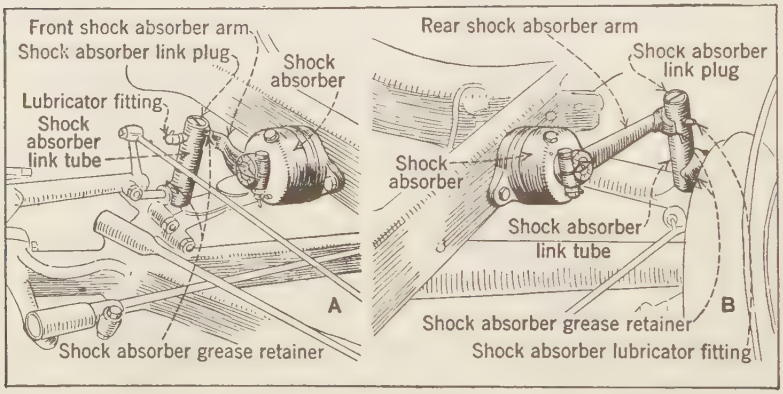

Fig. 34.—Location and Parts of Ford Model A Hydraulic Shock Absorbers.

shock absorbers and 3 for the rears. Turning the needle valve changes the adjustment. Resistance is increased when the needle valve is turned from 1 to 8 and decreased from 8 back to 1. A slight movement of the needle valve either way makes a big difference in the action of the instruments.

The only care the shock absorbers require is replenishing the glycerine in the reservoir and the lubrication of the ball joints. The filler plug in the reservoir should be removed at intervals of 5,000 to 10,000 miles, and the reservoir filled with glycerine (Commercial). NEVER

REPLENISH WITH OIL. Oil will solidify in the winter or reduce resistance, and will not mix with the glycerine in the instruments. In warm climates, replenish with glycerine, C. P. or Commercial. All instruments contain glycerine with 10% alcohol. Where temperatures of zero and below are prevalent, add additional alcohol, not to exceed 20% of the volume.

The ball joint in itself is made in unit with the instrument arm. It is hardened and ground. The ball joint seats are enclosed in the shock absorber connecting links, which should be lubricated every 500 miles with the compressor gun. In order to secure maximum riding comfort, it is important that the spring hangers be free in the bushings and kept well greased.

The speedometer with which the Ford Model A car is equipped indicates the speed and records the mileage of the car. It also helps the user in maintaining an accurate lubrication schedule. To reset the trip odometer, simply pull out the knob on the speedometer. By turning the knob you can reset the figures at any tenth of a mile desired, or back to zero. After resetting the odometer, be sure to push the knob back to its original position.

The flexible shaft should be lubricated every 5,000 miles. Care should be exercised not to bend the shaft in a radius smaller than 7 in. For maximum service we recommend that every 10,000 miles the speedometer be cleaned, lubricated and recalibrated. When this is necessary, or when repairs are required, consult an authorized dealer. All speedometers are sealed when they leave the factory. Under no circumstances should this seal be broken or repairs attempted by the owner.

The Proper Way to Wash the Car.—Always use cold or lukewarm water—never hot water. If a hose is used,

don't turn the water on at full force. This drives the dirt into the finish. After the surplus mud and grime have been washed off, take a sponge and clean the body and running gear with a solution of water and linseed oil soap. Rinse off with cold water; then rub and polish the body with a damp chamois skin. A body polish of good quality may be used to add luster to the car. Grease on the running gear may be removed with a gasoline-soaked sponge or rag. The nickeled parts may be polished with a good nickel polish. An excellent body polish and nickel polish can be purchased from any Ford dealer.

Should the body or other pyroxylin finished parts of the car become spattered with tar or other substances used on roads, the spots can be removed with a solution of two-thirds gasoline and one-third oil. If full strength gasoline is used, there is a possibility of softening the finish. Dip a soft cloth into the mixture and, using one finger, rub the spot gently until it has been removed. The rubbed spot should then be washed off with clear water.

Care of the Top.—When putting down the top be careful in folding to see that the fabric is not pinched between the bow spacers, as they will chafe a hole through the top very quickly. Applying Ford top dressing will greatly improve the appearance of an old top.

Storing the Car.—Drain the water from the radiator, then put in about a quart of anti-freeze solution to prevent any freezing of the water that may possibly remain. Draw off all gasoline. Drain the old oil from the oil pan. Refill the oil pan with one gallon of fresh oil and run the engine enough to cover the different parts with oil. Remove the tires and store them. Wash the car and, if possible, cover the body with a sheet of muslin to protect the finish.

FORD MODEL A ONE AND ONE-HALF TON TRUCK

The care and general operating instructions pertaining to the car also apply to the truck, with the exception that a new truck should not be driven faster than 20 to 25 miles per hour for the first 500 miles, and all tires

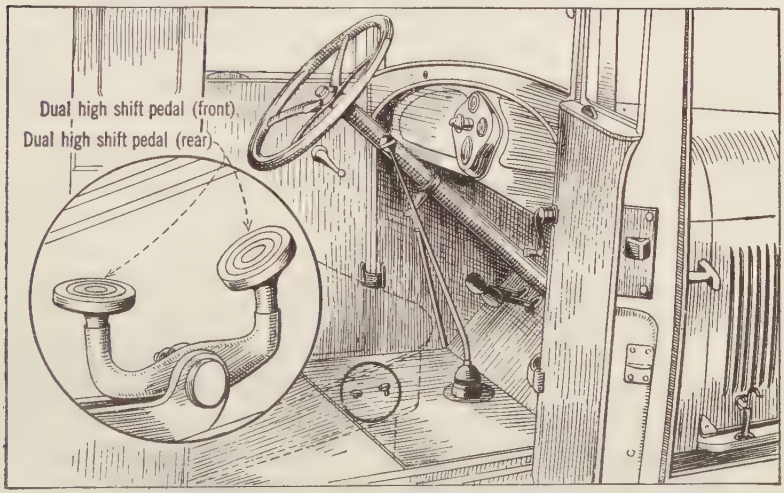

Fig. 35.—Location of Dual High Transmission Control Pedals on Ford Model AA Truck.

should be inflated to 80 pounds and the pressure checked every week.

Dual High.—The dual high transmission, which is optional equipment, gives the truck approximately one-third more pulling power. It is operated by a double end shift pedal which extends through the floor boards. Pressing down on the rear pedal engages the dual high. Pressing down on the front pedal disengages it. (See Fig. 35.)

This shift is entirely independent of any standard transmission gear shift and can be made at any speed in which the truck is being driven, whether high, second, low or reverse.

To engage the dual high remove your foot from the accelerator. Disengage the clutch, then press down on the rear dual high clutch pedal. As soon as the dual high is engaged, re-engage the clutch and press down on the accelerator until the desired driving speed is obtained.

To disengage the dual high, remove your foot from the accelerator. Disengage the clutch and press down on the front dual high clutch pedal. As soon as the dual high is disengaged, re-engage the clutch and press down on the accelerator until the desired driving speed is obtained.

SUMMARY OF FORD MODEL A ENGINE TROUBLES AND THEIR CAUSES

If starter turns engine over freely, check the following:

Ignition switch off.

Gasoline tank is empty or supply shut off.

If engine is cold, mixture may not be rich enough—choke button not pulled back. See starting instructions.

Warm engine—over-choking.

Breaker points too close. The correct adjustment is .015 to .018 in.

Spark plugs gaps too wide. Correct gap .025 in.

Water in sediment bulb or carburetor. See instructions for draining carburetor.

Starter Fails to Turn Engine Over.—Battery run down. A quick way to check this is to turn on the lights, and

depress the starter switch. If the battery is weak the lights will go out or grow quite dim. If the battery is run down, have it recharged.

Loose or dirty battery connections—see that both the negative and positive battery terminal connections are clean and tight. These connections should be checked regularly.

Missing at Low Speed. —Gas mixture too rich or too lean. See carburetor adjustment on page 547.

Too close a gap between spark plug points. The correct gap is .025 in.

Breaker points improperly adjusted, badly burnt or pitted. See instructions for adjusting breaker contact points. Fouled spark plug. Plugs should be occasionally cleaned and the gaps checked. Water in gasoline. See instructions on cleaning sediment bulb and carburetor.

Missing at High Speed. — Insufficient gasoline flowing to carburetor due due to gasoline line filter screen being partly clogged. Gas mixture too rich or too lean. See carburetor adjustment instructions. Water in gasoline. Drain sediment bulb and carburetor as described.

Engine Stops Suddenly.—Gasoline tank empty. Dirt in fuel line or carburetor. Gas mixture too lean.

Engine Overheats. —Lack of water—radiator should be kept well filled. Lack of oil—check oil level as described. Fan belt loose or slipping. See instructions for fan belt adjustment. Carbon deposit on piston heads and in combustion chamber. This can be corrected by taking off the cylinder head and removing the carbon. (Ford dealers are equipped for this work.) Incorrect spark timing. Follow ignition timing instructions. Gas mixture too rich. See instructions for adjustment of carburetor. Water circulation retarded by sediment in radiator.

Engine Knocks.—Carbon knock—caused by a deposit of carbon in combustion chamber and on piston heads. Take off cylinder head and remove carbon. Ignition knock—if this occurs under ordinary driving conditions, check ignition timing. Engine overheats. Check conditions listed under "Engine Overheats." Loose bearing. If a bearing has become loose, it should be adjusted by an authorized Ford mechanic.

Do not mistake an ignition knock for a loose bearing. Ignition knocks usually occur when the car is suddenly accelerated or when ascending a steep grade or traveling through heavy sand with the spark lever fully advanced. Slightly retarding the spark lever eliminates the knock. The spark should be advanced as soon as normal road conditions are encountered. Loose bearings knock all the time the engine is in use and regardless of spark timing.

The instructions given for repairing the Ford Model T engine in this book can be followed just as well in the new car, except that the structural details are different. Carbon removal, valve grinding, bearing fitting and adjustment, etc., are the same in practically all engines.

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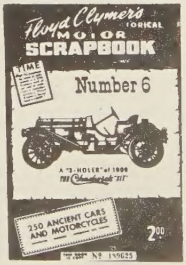

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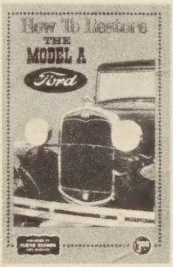

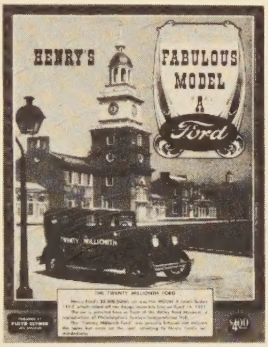

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This is the most fantastic book ever published on the Model A Ford. It is a "monster" with 560 pages and over 300 photographs, charts, and drawings. Written in 1929 and 1930 near the end of Model A production by S.A.E. member, Victor Page, who was then considered the most outstanding authority on Model A Ford cars.

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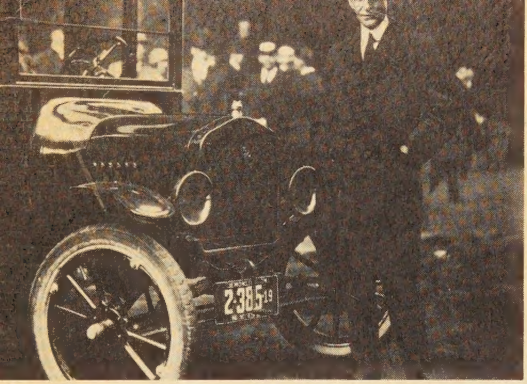
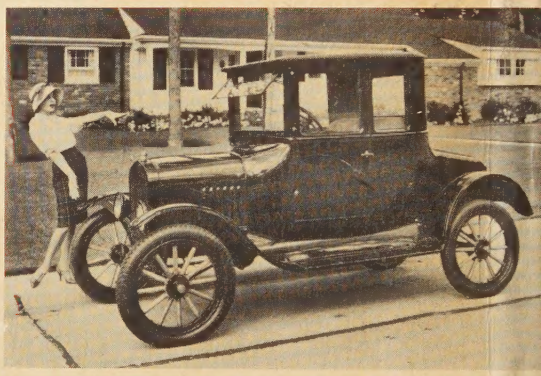
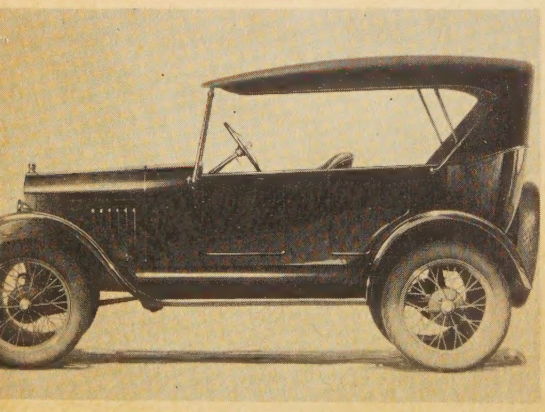


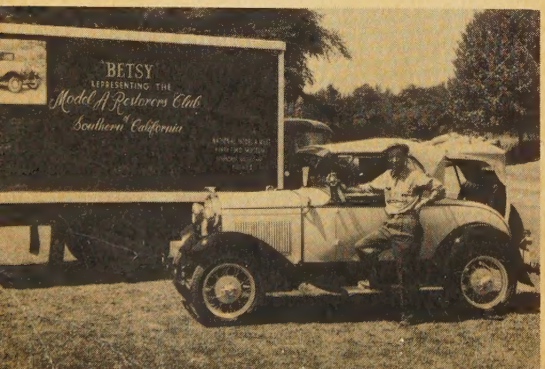
The man who started it all — the late Henry Ford — shown with one of the more than 15,000,000 Model T's he built between October, 1908 and May, 1927.

Of more than 15,000,000 Model T Fords built, it is estimated that some 40,000 still exist in America. Avid collectors scour the countryside looking for cars in restorable condition and prowl the junkyards searching for usable parts. The above 1923 model coupe was restored by a Dearborn, Mich., enthusiast.





One of the last Model T touring cars with wire wheels, spare tire on rear but Henry still had a taboo on four-wheel brakes which his competitors were using.



Claude Grow, of Glend Calif., shown above with prize-winning 1930 Sp Coupe, brought the caref restored vehicle by this s cial van to the 1957 F Model A Restorers Club national meet at Gree Village, Dearborn, Mi . The car won special prize or the most outstanding restoration "above and beyond the original Model A standards." Note his special truck used for transporting the Model A from California to Michigan.